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(54) Title: MULTICOLOR ORGANIC LIGHT EMITTING DEVICES (57) Abstract <p>A multicolor organic light emitting device employs vertically stacked layers of double heterostructure devices which are fabricated from organic compounds. The vertical stacked structure is formed on a glass base having a transparent coating of ITO or similar metal to provide a substrate. Deposited on the substrate is the vertical stacked arrangement of three double heterostructure devices, each fabricated from a suitable organic material. Stacking is implemented such that the double heterostructure with the longest wavelength is on the top of the stack. This constitutes the device emitting red light on the top with the device having the shortest wavelength, namely, the device emitting blue light, on the bottom of the stack. Located between the red and blue device structures is the green device structure. The devices are configured as stacked to provide a staircase profile whereby each device is separated from the other by a thin transparent conductive contact layer to enable light emanating from each of the devices to pass through the semitransparent contacts and through the lower device structures while further enabling each of the devices to receive a selective bias.</p> <p style="text-align: right;">DE</p>		

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MULTICOLOR ORGANIC LIGHT EMITTING DEVICES

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Field Of The Invention

This invention relates to multicolor organic light emitting devices and more particularly to such devices for use in flat panel electronic displays.

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Background Of The Invention

The electronic display is an indispensable way in modern society to deliver information and is utilized in television sets, computer terminals and in a host of other applications. No other medium offers its speed, versatility and interactivity. Known display technologies include plasma displays, light emitting diodes (LEDs), thin film electroluminescent displays, and so forth.

The primary non-emissive technology makes use of the electro optic properties of a class of organic molecules known as liquid crystals (LCs) or liquid crystal displays (LCDs). LCDs operate fairly reliably but have relatively low contrast and resolution, and require high power backlighting. Active matrix displays employ an array of transistors, each capable of activating a single LC pixel. There is no doubt that the technology concerning flat panel displays is of a significant concern and progress is continuously being made. See an article

entitled "Flat Panel Displays", Scientific American, March 1993, pgs. 90-97 by S.W. Depp and W.E. Howard. In that article, it is indicated that by 1995 flat panel displays alone are expected to form a market of between 4 and 5 billion dollars. Desirable factors for any display technology is the ability to provide a high resolution full color display at good light level and at competitive pricing.

Color displays operate with the three primary colors red (R), green (G) and blue (B). There has been considerable progress in demonstrating red, green and blue light emitting devices (LEDs) using organic thin film materials. These thin film materials are deposited under high vacuum conditions. Such techniques have been developed in numerous places throughout the world and this technology is being worked on in many research facilities.

Presently, the most favored high efficiency organic emissive structure is referred to as the double heterostructure LED which is shown in Fig. 1A and designated as prior art. This structure is very similar to conventional, inorganic LED's using materials as GaAs or InP.

In the device shown in Fig. 1A, a support layer of glass 10 is coated by a thin layer of Indium Tin Oxide (ITO) 11 which layers 10 and 11 form the substrate 8. Next, a thin (100-500 Å) organic, predominantly hole transporting layer (HTL) 12 is deposited on the ITO layer 11. Deposited on the surface of HTL layer 12 is a thin (typically, 50Å - 100Å) emission layer (EL) 13. If the layers are too thin there may be lack of continuity in the film, and thicker films tend to have a high

internal resistance requiring higher power operation. Emissive layer (EL) 13 provides the recombination site for electrons injected from a 100-500Å thick electron transporting layer 14 (ETL) with holes from the HTL layer 12. The ETL material is characterized by its considerably higher electron than hole mobility. Examples of prior art ETL, EL and HTL materials are disclosed in U.S. Patent No. 5,294,870 entitled "Organic Electroluminescent MultiColor Image Display Device", issued on March 15, 1994 to Tang et al.

Often, the EL layer 13 is doped with a highly fluorescent dye to tune color and increase the electroluminescent efficiency of the LED. The device as shown in Fig. 1A is completed by depositing metal contacts 15, 16 and top electrode 17. Contacts 15 and 16 are typically fabricated from indium or Ti/Pt/Au. Electrode 17 is often a dual layer structure consisting of an alloy such as Mg/Ag 17' directly contacting the organic ETL layer 14, and a thick, high work function metal layer 17'' such as gold (Au) or silver (Ag) on the Mg/Ag. The thick metal 17'' is opaque. When proper bias voltage is applied between top electrode 17 and contacts 15 and 16, light emission occurs through the glass substrate 10. An LED device of Fig. 1A typically has luminescent external quantum efficiencies of from 0.05 percent to 4 percent depending on the color of emission and its structure.

Another known organic emissive structure referred as a single heterostructure is shown in Fig. 1B and designated as prior art. The difference in this structure relative to that of Fig. 1A, is that the EL layer 13 serves also as an ETL layer,

eliminating the ETL layer 14 of Fig. 1A. However, the device of Fig. 1B, for efficient operation, must incorporate an EL layer 13 having good electron transport capability, otherwise a separate ETL layer 14 must be included as shown for the device of Fig. 1A.

Presently, the highest efficiencies have been observed in green LED's. Furthermore, drive voltages of 3 to 10 volts have been achieved. These early and very promising demonstrations have used amorphous or highly polycrystalline organic layers. These structures undoubtedly limit the charge carrier mobility across the film which, in turn, limits current and increases drive voltage. Migration and growth of crystallites arising from the polycrystalline state is a pronounced failure mode of such devices. Electrode contact degradation is also a pronounced failure mechanism.

Yet another known LED device is shown in Fig. 1C, illustrating a typical cross sectional view of a single layer (polymer) LED. As shown, the device includes a glass support layer 1, coated by a thin ITO layer 3, for forming the base substrate. A thin organic layer 5 of spin-coated polymer, for example, is formed over ITO layer 3, and provides all of the functions of the HTL, ETL, and EL layers of the previously described devices. A metal electrode layer 6 is formed over organic layer 5. The metal is typically Mg, Ca, or other conventionally used metals.

An example of a multicolor electroluminescent image display device employing organic compounds for light emitting pixels is disclosed in Tang et al., U.S. Patent No. 5,294,870.

This patent discloses a plurality of light emitting pixels which contain an organic medium for emitting blue light in blue-emitting subpixel regions. Fluorescent media are laterally spaced from the blue-emitting subpixel region. The fluorescent media absorb light emitted by the organic medium and emit red and green light in different subpixel regions. The use of materials doped with fluorescent dyes to emit green or red on absorption of blue light from the blue subpixel region is less efficient than direct formation via green or red LED's. The reason is that the efficiency will be the product of (quantum efficiency for EL)*(quantum efficiency for fluorescence)*(1-transmittance). Thus a drawback of this display is that different laterally spaced subpixel regions are required for each color emitted.

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Summary Of The Invention

It is an object of the present invention to provide a multicolor organic light emitting device employing several types of organic electroluminescent media, each for emitting a distinct color.

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It is a further object of this invention to provide such a device in a high definition multicolor display in which the organic media are arranged in a stacked configuration such that any color can be emitted from a common region of the display.

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It is another object of the present invention to provide a three color organic light emitting device which is extremely reliable and relatively inexpensive to produce.

It is a further object to provide such a device which is implemented by the growth of organic materials similar to those materials used in electroluminescent diodes, to obtain an organic LED which is highly reliable, compact, efficient and requires low drive voltages for utilization in RGB displays.

In one embodiment of the invention, a multicolor light emitting device (LED) structure comprises at least a first and a second organic LED stacked one upon the other, and preferably three, to form a layered structure, with each LED separated one from the other by a transparent conductive layer to enable each device to receive a separate bias potential to emit light through the stack.

Brief Description Of The Drawings

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Fig. 1A is a cross sectional view of a typical organic double heterostructure light emitting device (LED) according to the prior art.

Fig. 1B is a cross sectional view of a typical organic single heterostructure light emitting device (LED) according to the prior art.

Fig. 1C is a cross sectional view of a known single layer polymer LED structure according to the prior art.

Figs. 2A, 2B, and 2C are cross sectional views of an integrated three color pixel utilizing crystalline organic light emitting devices (LED's), respectively, according to embodiments of this invention, respectively.

Figs. 3-11 show a variety of organic compounds which may be used to comprise the active emission layers for generating the various colors.

5 Figs. 12(A-E) illustrate a shadow masking process for the fabrication of the multicolor LED according to the invention.

Figs. 13(A-F) illustrate a dry etching process for the fabrication of the multicolor LED according to the invention.

Fig. 14A shows a multicolor LED of one embodiment of this invention configured for facilitating packaging thereof.

10 Fig. 14B shows a cross sectional view of a hermetic package for another embodiment of the invention.

Fig. 14C is cross sectional view taken along 14C-14C of Fig. 14B.

15 Fig. 15 is a block diagram showing an RGB display utilizing LED devices according to this invention together with display drive circuitry.

Fig. 16 shows an LED device of another embodiment of the invention extending the number of stacked LED's to N, where N is an integer number 1, 2, 3,N.

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Detailed Description Of The Invention

Figure 1A has been described and is a prior art double heterostructure organic light emitting device. The basic
25 construction of the device of Fig. 1A is used in this invention as will be described.

Referring to Fig. 2A, there is shown a schematic cross section of a highly compact, integrated RGB pixel structure which

is implemented by grown or vacuum deposited organic layers, in one embodiment of the invention. Based on the ability to grow organic materials on a large variety of materials (including metals and ITO), one can construct a stack of LED double heterostructures (DH) designated as 20, 21 and 22, in one embodiment of the invention. For illustrative purposes, LED 20 is considered in a bottom portion of the stack, LED 21 in a middle portion of the stack, and LED 22 in a top portion of the stack, in the example of Fig. 2A. Also, the stack is shown to be vertically oriented in Fig. 2A, but the LED can be otherwise oriented. In other embodiments, a stack of single heterostructure (SH) LED's (see Fig. 1B), or a stack of polymer-based LED devices (see Fig. 1C), are viable alternatives to the DH LED's, with the SH devices being equally viable as DH devices for light emitters. Also, SH and DH devices comprising a combination of vacuum deposited and polymeric light-emitting materials are considered to be within the spirit and scope of this invention.

Each device structure as device 20, consists of an HTL layer 20H vacuum-deposited or grown on or otherwise deposited onto the surface of an ITO layer 35. A top ETL layer 20T sandwiches an EL layer 20E between the former and HTL layer 20H, for example, shown in the device construction of Fig. 2A. The ETL layer 20T and other ETL layers to be described are composed of organic materials such as M(8-hydroxyquinolate), (M=metal ion; n=2-4). Examples of other suitable organic ETL materials can be found in U.S. Patent No. 5,294,870 to Tang et al. Formed on top of ETL layer 20T is a thin, semi-transparent low work function

(preferably, <4 eV) metal layer 26M having a thickness typically less than 50\AA . Suitable candidates include Mg, Mg/Ag, and As. Deposited on the top of metal layer 26M is another transparent, thin conductive ITO layer 26I. (For convenience herein, the double layer structure of metallic layer 26M and ITO layer 26I is referred to as ITO/metal layers 26.) Each of the double heterostructure devices as 20, 21 and 22 have a bottom HTL layer formed on a transparent conductive layer of ITO 26I or 35. Next an EL layer is deposited and then another layer of ETL. Each of the HTL, ETL, ITO, metal and organic EL layers are transparent because of their composition and minimal thickness. Each HTL layer may be $50\text{-}1000\text{\AA}$ thick; each EL layer may be $50\text{-}200\text{\AA}$ thick; each ETL layer may be $50\text{-}1000\text{\AA}$ thick; each metal layer 26M may be $50\text{-}100\text{\AA}$ thick; and each ITO layer 26I and 35 may be $1000\text{-}4000\text{\AA}$ thick. For optimum performance, each of the layers should preferably be kept towards the lower ends of the above ranges. Thus, each LED 20, 21 and 22 (excluding ITO/metal layers) are preferably close to 200\AA thick.

If SH LED devices are used for providing LED's 20, 21, 22, rather than DH LED devices, the ETL and EL layers are provided by a single layer, such as layer 13, as previously described for the SH of Fig. 1B. This layer 13 is typically Al-quinolate. This is shown in Fig. 2B, where the EL layers 20E, 21E, and 22E, respectively, provide both the EL and ETL layer functions. However, an advantage of the DH LED stack of Fig. 2A, relative to a SH LED stack of Fig. 2B, is that the DH LED stack permits thinner overall construction with high efficiency.

In Figs. 2A and 2B, even though the centers of each of the LED's are offset from one another, the total beam of light from each device is substantially coincident between LED's 20, 21 and 22. While the beams of light are coincident in the concentric configuration, the emitting or non-emitting device closer to the glass substrate will be transparent to the emitting device or devices further away from the glass substrate. However, the diodes 20, 21 and 22 need not be offset from one another and may alternatively be stacked concentrically upon each other, whereupon the beam of light from each device is wholly coincident with the others. A concentric configuration is shown in Fig. 12E which will be described below in regard to device fabrication processes. Note that there is no difference in function between the offset and concentric configurations. Each device emits light through glass substrate 37 in a substantially omnidirectional pattern. The voltages across, the three LED's in the stack 29 are controlled to provide a desired resultant emission color and brightness for the particular pixel at any instant of time. Thus, each LED as 22, 21 and 20 can be energized simultaneously with beams as R, G and B, respectively, for example, directed through and visible via the transparent layers, as shown schematically in Figs. 2A and 2B. Each DH structure 20, 21 and 22 is capable upon application of a suitable bias voltage of emitting a different color light. The double heterostructure LED 20 emits blue light. The double heterostructure LED 21 emits green light while the double heterostructure (DH) LED 22 emits red light. Different combinations or individual ones of LED's 20, 21 and 22 can be

activated to selectively obtain a desired color of light for the respective pixel partly dependent upon the magnitude of current in each of the LED's 20, 21 and 22.

In the example of Figs. 2A and 2B, LED's 20, 21 and 22
5 are forward biased by batteries 32, 31 and 30, respectively. Current flows from the positive terminal of each battery 32, 31 and 30, into the anode terminal 40, 41, 42, respectively, of its associated LED 20, 21 and 22, respectively, through the layers of each respective device, and from terminals 21, 21 and 43,
10 serving as cathode terminals to negative terminals of each battery 32, 31, and 30, respectively. As a result, light is emitted from each of the LED's 20, 21 and 22. The LED devices 20, 21 and 22 are made selectively energizable by including means (not shown) for selectively switching batteries 32, 31 and 30,
15 respectively, into and out of connection to their respective LED.

In the embodiments of the invention, relative to Figs. 2A and 2B, the top ITO contact 26I for LED 22 is transparent, making the three color device shown useful for headup display applications. However, in another embodiment of the invention,
20 the top contact 26I is formed from a thick metal, such as either Mg/Ag, In, Ag, or Au, for reflecting light emitted upward back through substrate 13, for substantially increasing the efficiency of the device. Also, overall device efficiency can be increased by forming a multilayer dielectric thin film coating between
25 glass substrate 37 and the ITO layer 35, to provide an anti-reflecting surface. Three sets of anti-reflecting layers are required, one to form an anti-reflection coating at each wavelength emitted from the various layers.

In another embodiment, the device of Fig. 2A is constructed in an opposite or inverted manner, for providing light emission out of the top of stack rather than the bottom as the former. An example of an inverted structure, with reference to Fig. 2C, is to replace ITO layer 35 with a thick, reflective metal layer 38. Blue LED 20 is then provided by interchanging HTL layer 20H and ETL layer 20T, with EL layer 20E remaining sandwiched between the latter two layers. Furthermore, the metal contact layer 26M is now deposited on top of ITO layer 26I. The green LED 21 and red LED 22 portions of the stack are each constructed with inverted layers (the HTL and EL layers of each are interchanged, followed by inverting the metal and ITO layers) as described for the inverted blue LED 20. Note that in the inverted structure, the blue device 20 must be on top and the red device 22 on the bottom. Also, the polarities of batteries 30, 31, and 32 are reversed. As a result, the current flow through devices 20, 21 and 22, respectively, is in the opposite direction relative to the embodiment of Fig. 2A, when forward biased for emitting light.

The device in the cross sectional view has a step-like or staircase profile, in this example. The transparent contact areas (ITO) 26I permit separate biasing of each pixel element in the stack and furthermore the material can be used as an etch stop during the processing steps. The separate biasing of each DH LED structure 20, 21 and 22 allows for wavelength tuning of the pixel output to any of various desired colors of the visible spectrum as defined in the CIE (Commission Internationale de l'Eclairage/International Commission of Illumination)

chromaticity standard. The blue emitting LED 20 is placed at the bottom of the stack and it is the largest of the three devices. Blue is on the bottom because it is transparent to red and green light. Finally, the materials "partitioning" using the transparent ITO/metal layers 26 facilitates manufacture of this device as will be described. It is the very unique aspects of the vacuum growth and fabrication processes associated with organic compounds which makes the pixel LED devices shown in Figs. 2A, 2B, and 2C possible. The vertical layering shown in Figs. 2A, 2B, and 2C allows for the fabrication of three color pixels with the smallest possible area, hence, making these ideal for high definition displays.

As seen in Figs. 2A, 2B, and 2C, each device DH structure 20, 21 and 22 can emit light designated by arrows B, G and R, respectively, either simultaneously or separately. Note that the emitted light is from substantially the entire transverse portion of each LED 20, 21 and 22, whereby the R, G, and B arrows are not representative of the width of the actual emitted light, respectively. In this way, the addition or subtraction of colors as R, G and B is integrated by the eye causing different colors and hues to be perceived. This is well known in the field of color vision and display colorimetry. In the offset configuration shown, the red, green and blue beams of light are substantially coincident. If the devices are made small enough, that is about 50 microns or less, any one of a variety of colors can be produced from the stack. However, it will appear as one color originating from a single pixel.

The organic materials used in the DH structures are grown one on top of the other or are vertically stacked with the longest wavelength device 22 indicative of red light on the top and the shortest wavelength element 20 indicative of blue light on the bottom. In this manner, one minimizes light absorption in the pixel or in the devices. Each of the DH LED devices are separated by ITO/metal layers 26 (specifically, semitransparent metal layers 26M, and indium tin oxide layers 26I). The ITO layers 26I can further be treated by metal deposition to provide distinct contact areas on the exposed ITO surfaces, such as contacts 40, 41, 42 and 43. These contacts 40, 41, 42 and 43 are fabricated from indium, platinum, gold, silver or alloys such as Ti/Pt/Au, Cr/Au, or Mg/Ag, for example. Techniques for deposition of contacts using conventional metal deposition or vapor deposition are well known. The contacts, such as 40, 41, 42 and 43, enable separate biasing of each LED in the stack. The significant chemical differences between the organic LED materials and the transparent electrodes 26I permits the electrodes to act as etch stop layers. This allows for the selective etching and exposure of each pixel element during device processing.

Each LED 20, 21, 22 has its own source of bias potential, in this example shown schematically as batteries 32, 31, and 30, respectively, which enables each LED to emit light. It is understood that suitable signals can be employed in lieu of the batteries 30, 31, 32, respectively. As is known, the LED requires a minimum threshold voltage to emit light (each DH LED)

and hence this activating voltage is shown schematically by the battery symbol.

The EL layers 20E, 21E, 22E may be fabricated from organic compounds selected according to their ability to produce all primary colors and intermediates thereof. The organic compounds are generally selected from trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth mixed chelates, as described hereinafter.

The trivalent metal quinolate complexes are represented by the structural formula shown in Fig. 3, wherein M is a trivalent metal ion selected from Groups 3-13 of the Periodic Table and the Lanthanides. Al^{+3} , Ga^{+3} and In^{+3} are the preferred trivalent metal ions.

R of Fig. 3 includes hydrogen, substituted and unsubstituted alkyl, aryl and heterocyclic groups. The alkyl group may be straight or branched chain and preferably has from 1 to 8 carbon atoms. Examples of suitable alkyl groups are methyl and ethyl. The preferred aryl group is phenyl and examples of the heterocyclic group for R include pyridyl, imidazole, furan and thiophene.

The alkyl, aryl and heterocyclic groups of R may be substituted with at least one substituent selected from aryl, halogen, cyano and alkoxy, preferably having from 1 to 8 carbon atoms. The preferred halogen is chloro.

The group L of Fig. 3 represents a ligand including picolylmethylketone, substituted and unsubstituted salicylaldehyde (e.g. salicylaldehyde substituted with barbituric acid), a group of the formula $R(O)CO-$ wherein R is as defined above, halogen, a group of the formula $RO-$ wherein R is as defined above, and quinolates (e.g. 8-hydroxyquinoline) and derivatives thereof (e.g. barbituric acid substituted quinolates). Preferred complexes covered by the formula shown in Fig. 3 are those where M is Ga^{+3} and L is chloro. Such compounds generate a blue emission. When M is Ga^{+3} and L is methyl carboxylate, complexes emitting in the blue to blue/green region are produced. A yellow or red emission is expected by using either a barbituric acid substituted salicylaldehyde or a barbituric acid substituted 8-hydroxyquinoline for the L group. Green emissions may be produced by using a quinolate for the L group.

The trivalent metal bridged quinolate complexes which may be employed in the present invention are shown in Figs. 4A and 4B. These complexes generate green emissions and exhibit superior environmental stability compared to trisquinolates (complexes of Fig. 3 where L is a quinolate) used in prior art devices. The trivalent metal ion M used in these complexes is as defined above with Al^{+3} , Ga^{+3} , or In^{+3} being preferred. The group Z shown in Fig. 4A has the formula SiR wherein R is as defined above. Z may also be a group of the formula $P=O$ which forms a phosphate.

The Schiff base divalent metal complexes include those shown in Figs. 5A and 5B wherein M^I is a divalent metal chosen from Groups 2-12 of the Periodic Table, preferably Zn (See, Y. Hanada, et al., "Blue Electroluminescence in Thin Films of Axonethin - Zinc Complexes", Japanese Journal of Applied Physics Vol. 32, pp. L511 - L513 (1993). The group R^I is selected from the structural formulas shown in Figs. 5A and 5B. The R^I group is preferably coordinated to the metal of the complex through the amine or nitrogen of the pyridyl group. X is selected from hydrogen, alkyl, alkoxy, each having from 1 to 8 carbon atoms, aryl, a heterocyclic group, phosphino, halide and amine. The preferred aryl group is phenyl and the preferred heterocyclic group is selected from pyridyl, imidazole, furan and thiophene. The X groups affect the solubility of the Schiff base divalent metal complexes in organic solvents. The particular Schiff base divalent metal complex shown in Fig. 5B emits at a wavelength of 520nm.

The tin (iv) metal complexes employed in the present invention in the EL layers generate green emissions. Included among these complexes are those having the formula SnL^1L^2 , where L^1 is selected from salicylaldehydes, salicyclic acid or quinolates (e.g. 8-hydroxyquinoline). L^2 includes all groups as previously defined for R except hydrogen. For example, tin (iv) metal complexes where L^1 is a quinolate and L^2 is phenyl have an emission wavelength (λ_{em}) of 504nm, the wavelength resulting from measurements of photoluminescence in the solid state.

The tin (iv) metal complexes also include those having the structural formula of Fig. 6 wherein Y is sulfur or NR^2 where

R^2 is selected from hydrogen and substituted or unsubstituted, alkyl and aryl. The alkyl group may be straight or branched chain and preferably has from 1 to 8 carbon atoms. The preferred aryl group is phenyl. The substituents for the alkyl and aryl groups include alkyl and alkoxy having from 1 to 8 carbon atoms, cyano and halogen. L^3 may be selected from alkyl, aryl, halide, quinolates (e.g. 8-hydroxyquinoline), salicylaldehydes, salicylic acid, and maleonitriledithiolate ("mnt"). When A is S and Y is CN and L^3 is "mnt" an emission between red and orange is expected.

The M(acetylacetonate), complexes shown in Fig. 7 generate a blue emission. The metal ion M is selected from trivalent metals of Groups 3-13 of the Periodic Table and the Lanthanides. The preferred metal ions are Al^{+3} , Ga^{+3} and In^{+3} . The group R in Fig. 7 is the same as defined for R in Fig. 3. For example, when R is methyl, and M is selected from Al^{+3} , Ga^{+3} and In^{+3} , respectively, the wavelengths resulting from the measurements of photoluminescence in the solid state is 415nm, 445nm and 457nm, respectively (See J. Kido et al., "Organic Electroluminescent Devices using Lanthanide Complexes", Journal of Alloys and Compounds, Vol. 92, pp. 30-33 (1993)).

The metal bidentate complexes employed in the present invention generally produce blue emissions.

Such complexes have the formula MDL^4_2 , wherein M is selected from trivalent metals of Groups 3-13 of the Periodic Table and the Lanthanides. The preferred metal ions are Al^{+3} , Ga^{+3} , In^{+3} and Sc^{+3} . D is a bidentate ligand examples of which are shown in Fig. 8A. More specifically, the bidentate ligand

D includes 2-picolylketones, 2-quinaldylketones and 2-(o-phenoxy) pyridine ketones where the R groups in Fig. 8A are as defined above.

The preferred groups for L' include acetylacetonate; compounds of the formula OR^3R wherein R^3 is selected from Si, C and R is selected from the same groups as described above; 3, 5-di(t-bu) phenol; 2, 6-di(t-bu) phenol; 2, 6-di(t-bu) cresol; and H_2Bpz_2 , the latter compounds being shown in Figs. 8B-8E, respectively.

By way of example, the wavelength (λ_{em}) resulting from measurement of photoluminescence in the solid state of aluminum (picolymethylketone) bis [2, 6-di(t-bu) phenoxide] is 420nm. The cresol derivative of the above compound also measured 420 nm. Aluminum (picolymethylketone) bis (OSiPh₃) and scandium (4-methoxy-picolymethylketone) bis (acetylacetonate) each measured 433nm, while aluminum [2-(O-phenoxy)pyridine] bis [2, 6-di(t-bu) phenoxide] measured 450nm.

Bisphosphonate compounds are another class of compounds which may be used in accordance with the present invention for the EL layers. The bisphosphonates are represented by the general formula:



M^2 is a metal ion. It is a tetravalent metal ion (e.g. Zr^{+4} , Ti^{+4} and Hf^{+4} when x and y both equal 1. When x is 3 and y is 2, the metal ion M^2 is in the divalent state and includes, for example, Zn^{+2} , Cu^{+2} and Cd^{+2} . The term "organic" as used in the

above formula means any aromatic or heterocyclic fluorescent compound that can be bifunctionalized with phosphonate groups.

The preferred bisphosphonate compounds include phenylene vinylene bisphosphonates as for example those shown in Figs. 9A and 9B. Specifically, Fig. 9A shows β -styrenyl stilbene bisphosphonates and Fig. 9B shows 4, 4'-biphenyl di(vinylphosphonates) where R is as described previously and R' is selected from substituted and unsubstituted alkyl groups, preferably having 1-8 carbon atoms, and aryl. The preferred alkyl groups are methyl and ethyl. The preferred aryl group is phenyl. The preferred substituents for the alkyl and aryl groups include at least one substituent selected from aryl, halogen, cyano, alkoxy, preferably having from 1 to 8 carbon atoms.

The divalent metal maleonitriledithiolate ("mnt") complexes have the structural formula shown in Fig. 10. The divalent metal ion M² includes all metal ions having a +2 charge, preferably transition metal ions such as Pt⁺², Zn⁺² and Pd⁺². Y' is selected from cyano and substituted or unsubstituted phenyl. The preferred substituents for phenyl are selected from alkyl, cyano, chloro and 1, 2, 2-tricyanovinyl.

L^s represents a group having no charge. Preferred groups for L^s include P(OR), and P(R), where R is as described above or L^s may be a chelating ligand such as, for example, 2, 2'-dipyridyl; phenanthroline; 1, 5-cyclooctadiene; or bis(diphenylphosphino)methane.

Illustrative examples of the emission wavelengths of various combinations of these compounds are shown in Table 1, as

derived from C.E. Johnson et al., "Luminescent Iridium(I), Rhodium(I), and Platinum(II) Dithiolate Complexes", Journal of the American Chemical Society, Vol. 105, pg. 1795 (1983).

5

Table 1

	<u>Complex</u>	<u>Wavelength*</u>
	[Platinum(1, 5-cyclooctadiene)(mnt)]	560nm
	[Platinum(P(OEt) ₃) ₂ (mnt)]	566nm
	[Platinum(P(OPh) ₃) ₂ (mnt)]	605nm
10	[Platinum(bis(diphenylphosphino)methane)(mnt)]	610nm
	[Platinum(PPh ₃) ₂ (mnt)]	652nm

*wavelength resulting from measurement of photoluminescence in the solid state.

15

Molecular charge transfer complexes employed in the present invention for the EL layers are those including an electron acceptor structure complexed with an electron donor structure. Figs. 11A-11E show a variety of suitable electron acceptors which may form a charge transfer complex with one of the electron donor structures shown in Figs. 11F-11J. The group R as shown in Figs. 11A and 11H is the same as described above.

Films of these charge transfer materials are prepared by either evaporating donor and acceptor molecules from separate cells onto the substrate, or by evaporating the pre-made charge transfer complex directly. The emission wavelengths may range from red to blue, depending upon which acceptor is coupled with which donor.

Polymers of aromatic and heterocyclic compounds which are fluorescent in the solid state may be employed in the present

invention for the EL Layers. Such polymers may be used to generate a variety of different colored emissions. Table II provides examples of suitable polymers and the color of their associated emissions.

5

Table II

	<u>POLYMER</u>	<u>EMISSION COLOR</u>
	poly(para-phenylenevinylene)	blue to green
	poly(dialkoxyphenylenevinylene)	red/orange
10	poly(thiophene)	red
	poly(phenylene)	blue
	poly(phenylacetylene)	yellow to red
	poly(N-vinylcarbazole)	blue

15

The rare earth mixed chelates for use in the present invention include any lanthanide elements (e.g. La, Pr, Nd, Sm, Eu, and Tb) bonded to a bidentate aromatic or heterocyclic ligand. The bidentate ligand serves to transport carriers (e.g. electrons) but does not absorb the emission energy. Thus, the bidentate ligands serve to transfer energy to the metal. Examples of the ligand in the rare earth mixed chelates include salicylaldehydes and derivatives thereof, salicyclic acid, quinolates, Schiff base ligands, acetylacetonates, phenanthroline, bipyridine, quinoline and pyridine.

20

25

The hole transporting layers 20H, 21H and 22H may be comprised of a porphorinic compound. In addition, the hole transporting layers 20H, 21H and 22H may have at least one hole transporting aromatic tertiary amine which is a compound

containing at least one trivalent nitrogen atom that is bonded only to carbon atoms, at least one of which is a member of an aromatic ring. For example, the aromatic tertiary amine can be an arylamine, such as a monoarylamine, diarylamine, triarylamine, or a polymeric arylamine. Other suitable aromatic tertiary amines, as well as all porphyrinic compounds, are disclosed in Tang et al., U.S. Patent No. 5,294,870, the teachings of which are incorporated herein in their entirety by reference, provided any of such teachings are not inconsistent with any teaching herein.

The fabrication of a stacked organic LED tricolor pixel according to the present invention may be accomplished by either of two processes: a shadow masking process or a dry etching process. Both processes to be described assume, for illustrative purposes, a double heterostructure LED construction, i.e., utilizing only one organic compound layer for each active emission layer, with light emerging from the bottom glass substrate surface. It should be understood that multiple heterojunction organic LED's having multiple organic compound layers for each active emission layer, and/or inverted structures (with light emerging from the top surface of the stack) can also be fabricated by one skilled in the art making slight modifications to the processes described.

The shadow masking process steps according to the present invention are illustrated in Figs. 12(A-E). A glass substrate 50 to be coated with a layer of ITO 52 is first cleaned by immersing the substrate 50 for about five minutes in boiling trichloroethylene or a similar chlorinated hydrocarbon. This is

followed by rinsing in acetone for about five minutes and then in methyl alcohol for approximately five minutes. The substrate 50 is then blown dry with ultrahigh purity (UHP) nitrogen. All of the cleaning solvents used are preferably "electronic grade".

5 After the cleaning procedure, the ITO layer 52 is formed on substrate 50 in a vacuum using conventional sputtering or electron beam methods.

A blue emitting LED 55 (see Figure 12B) is then fabricated on the ITO layer 52 as follows. A shadow mask 73 is
10 placed on predetermined outer portions of the ITO layer 52. The shadow mask 73 and other masks used during the shadow masking process should be introduced and removed between process steps without exposing the device to moisture, oxygen and other contaminants which would reduce the operational lifetime of the
15 device. This may be accomplished by changing masks in an environment flooded with nitrogen or an inert gas, or by placing the masks remotely onto the device surface in the vacuum environment by remote handling techniques. Through the opening of mask 73, a 50-100Å thick hole transporting layer (HTL) 54 and
20 50-200Å thick blue emission layer (EL) 56 (shown in Fig. 12B) are sequentially deposited without exposure to air, i.e., in a vacuum. An electron transporting layer (ETL) 58 having a thickness preferably of 50-1000Å is then deposited on EL 56. ETL 58 is then topped with a semitransparent metal layer 60M which
25 may preferably consist of a 10% Ag in 90% Mg layer, or other low work function metal or metal alloy layer, for example. Layer 60M is very thin, preferably less than 100Å. Layers 54, 56, 58 and 60M may be deposited by any one of a number of conventional

directional deposition techniques such as vapor phase deposition, ion beam deposition, electron beam deposition, sputtering and laser ablation.

5 An ITO contact layer 60I of about 1000-4000Å thick is then formed on the metal layer 60M by means of conventional sputtering or electron beam methods. For convenience herein, the sandwich layers 60M and 60I will be referred to and shown as a single layer 60, which is substantially the same as the layer 26 of Fig. 2. The low work function metal portion 60M of each
10 layer 60 directly contacts the ETL layer beneath it, while the ITO layer 60I contacts the HTL layer immediately above it. Note that the entire device fabrication process is best accomplished by maintaining the vacuum throughout without disturbing the vacuum between steps.

15 Fig. 12C shows a green emitting LED 65 which is fabricated on top of layer 60 using substantially the same shadow masking and deposition techniques as those used to fabricate blue emitting LED 55. LED 65 comprises HTL 62, green emission layer 64 and ETL 66. A second thin (<100Å thick, thin
20 enough to be semi-transparent but not so thin to lose electrical continuity) metal layer 60M is deposited on ETL layer 66, followed by another 1000-4000Å thick ITO layer 60I to form a second sandwich layer 60.

25 Shown in Fig. 12D is a red emitting LED 75 fabricated upon layer 60 (upon 60I to be specific) using similar shadow masking and metal deposition methods. Red emitting LED 75 consists of a HTL 70, a red emitting EL 72 and ETL 74. A top sandwich layer 60 of layers 60I and 60M are then formed on LED

75. As described above for the embodiment of Fig. 2, similarly, the top transparent ITO layer 60I can in an alternative embodiment be replaced by an appropriate metal electrode serving also to function as a mirror for reflecting upwardly directed light back through the substrate 50, thereby decreasing light losses out of the top of the device. Each ETL layer 74, 66 and 58 has a thickness of 50-200Å; each HTL layer 54, 62 and 70 is 100-500Å thick; and each EL layer 56, 64 and 72 is 50-1000Å thick. For optimum brightness and efficiency, each of the layers including the ITO/metal layers should be kept as close as possible towards the lower end of the above ranges.

The formation of electrical contacts 51 and 59 on ITO layer 52, and electrical contacts 88, 89, 92, 94 and 96 on the ITO portion 60I of ITO/metal layers 60 is then preferably accomplished in one step. These electrical contacts may be indium, platinum, gold, silver or combinations such as Ti/Pt/Au, Cr/Au or Mg/Ag. They may be deposited by vapor deposition or other suitable metal deposition techniques after masking off the rest of the device.

The final step in the shadow masking process is to overcoat the entire device with an insulating layer 97 as shown in Fig. 12E, with the exception of all the metal contacts 51, 59, 88, 89, 92, 94 and 96 which are masked. Insulating layer 97 is impervious to moisture, oxygen and other contaminants thereby preventing contamination of the LED's. Insulating layer 97 may be SiO₂, a silicon nitride such as Si₃N₄, or other insulator deposited by electron-beam, sputtering, or pyrolytically enhanced or plasma enhanced CVD. The deposition technique used should not

elevate the device temperature above 120°C inasmuch as these high temperatures may degrade the LED characteristics.

The dry etching process for fabricating the LED stack according to the invention is illustrated in Figs. 13(A-F). Referring to Fig. 13A, a glass substrate 102 is first cleaned in the same manner as in the shadow-mask process described above. An ITO layer 101 is then deposited on the glass substrate 102 in a vacuum using conventional sputtering or electron beam methods. An HTL 104, blue EL 105, ETL 106 and sandwich layer comprising metal layer 107M and ITO layer 107I, all of generally the same thicknesses as in the shadow-masking process, are then deposited over the full surface of the ITO layer 101, using either conventional vacuum deposition, or in the case of polymers spin or spray coating techniques. ITO/metal sandwich layer 107 consists of a less than 100Å thick, low work function metal layer 107M deposited directly on the ETL layer 106, and a 1000-4000Å thick ITO layer 107I on the metal layer 107M. On the entire top surface of ITO layer 107I, a 1000Å-2000Å thick layer of silicon nitride or silicon dioxide masking material 108 is deposited using low temperature plasma CVD. A positive photoresist layer 109 such as HPR 1400 J is then spun-on the silicon nitride layer 108. As shown in Fig. 13B the outer portions 110 (see Fig. 13A) of the photoresist layer 109 are exposed and removed using standard photolithographic processes. The exposed outer portions 110 correspond to the areas where the bottom ITO layer 101 is to be exposed and electrically contacted. Referring to Fig. 13C, the outer regions 111 (defined in Fig. 13B) of the silicon nitride layer 108 corresponding to the removed photoresist areas,

are removed using a $CF_4:O_2$ plasma. Then, using an ion milling technique or another plasma etch, the exposed outer portions of ITO/metal layers 107I and 107M are removed. An O_2 plasma is then employed to sequentially remove the corresponding exposed outer portion of the ETL layer 106, EL layer 105, and HTL layer 104, respectively, and also to remove the remaining photoresist layer shown in Fig. 13D. Finally, a $CF_4:O_2$ plasma is again applied to remove the silicon nitride mask 108, with the resulting blue LED configuration shown in Fig. 13D.

10 The same sequence of dry etching process steps is used to fabricate a green LED 115 atop the blue LED, except that $SiNx$ 150 is overlaid as shown, followed by a photoresist mask 113 as shown in Fig. 13E to mask the outer portion of ITO layer 101. Then the deposition of HTL layer 114, green EL layer 116, and so on is performed (see Fig. 13F). The same photolithography and etching techniques used for blue LED fabrication are then employed to complete the formation of the green LED 115. The red LED 117 is then formed atop the green LED using substantially the same dry etching process. A passivation layer 119 similar to layer 97 of Fig. 12E is then deposited over the LED stack with suitable patterning to expose electrical contacts, as was described for the shadow masking process. A photoresist mask is used to allow dry etching of holes in passivation layer 119. Next, metal 152 is deposited in the holes. A final photoresist layer and excess metal is removed by a "lift-off" process.

25 Following the LED stack fabrication, whether performed by a shadow mask, dry-etching or other method, the stack must be properly packaged to achieve acceptable device performance and

reliability. Figs. 14(A-C) illustrate embodiments of the invention for facilitating packaging, and for providing a hermetic package for up to four of the multicolor LED devices of the invention, for example. The same reference numerals used in
5 Figs. 14 (A-B) indicate the identical respective features as in Fig. 12E. The package may also be used with the nearly identical structure of Fig. 13F. Referring to Fig. 14A, after overcoating the entire device with an insulating layer 97, such as SiNx for example, access holes 120, 122, and 124 are formed using known
10 etching/photomasking techniques to expose the topmost metal layers 60M', 60M'', and 60M''', for the blue, green, and red LED (organic light emitting diode) devices, respectively, in this example. Thereafter, suitable metal circuit paths 126, 128, and 130 (typically of gold material), are deposited in a path from
15 the exposed metal layers 60M', 60M'', and 60M''', respectively, to edge located indium solder bumps 132, 133, and 134, respectively, using conventional processing steps. Similarly, an anode electrode termination is provided via the metal (Au, for example) circuit path 135 formed to have an inner end contacting
20 ITO layer 52, and an outer end terminating at an edge located indium solder bump 136, all provided via conventional processing. The device is then overcoated with additional insulating material such as SiNx to form an insulated covering with solder bumps 132, 133, 134, and 136 being exposed along one edge. In this manner,
25 the organic LED device can be readily packaged using conventional techniques, or the packaging embodiment of the invention as described immediately below.

A method for making four multicolor LED devices on a common substrate 50 in a packaged configuration will now be described, with reference to Figs. 14A, 14B, and 14C, respectively, for another embodiment of the invention. The starting material includes a glass substrate 50 coated with an overlayer of indium tin oxide (ITO) 152. The following steps are used to obtain the packaged multicolor organic LED array:

1. Mask ITO layer 52 to deposit an SiO_2 layer 138 in a concentric square band ring pattern, in this example (some other pattern can be employed), on top of ITO layer 52 using conventional techniques.

2. Form four three-color LED stacks sharing common layers in region 140 on the SiO_2 layer 138 using methods as taught above for obtaining, for example, either of the structures of Figs. 12E or 13F, and 14A.

3. Deposit via shadow masking metal contacts 170 through 181; each terminating at exterior ends on SiO_2 layer 138, for providing external electrical connecting or bonding pads 170 through 181', respectively. Note that contacts 126, 128, and 130 in Fig. 14A are the same as every successive three of contacts 170-181, respectively. Each group of three contacts, namely 170 through 172, 173 through 175, 176 through 178, and 179 through 181, terminate at their interior or other ends to provide an electrical connection with the metal layers 60M', 60M'', 60M''', respectively, of each of the four organic LED devices, respectively. Another metal contact 182 is deposited via shadow masking on an edge of ITO layer 52 common to all four of the LED devices, for providing a common anode connection, in this

example. Note that if through appropriate masking and etching the four LED devices are made in completely independent layers, four anode contacts, respectively, will have to be provided for the latter array that can be operated in a multiplexed manner. The
5 multicolor LED array being described in this example is a non-multiplexed array.

4. Deposit via shadow masking, for example, a second SiO_2 layer 184 in a continuous band or ring leaving exposed bonding pads 170' through 181', using either sputtering, or
10 plasma enhanced CVD, or electron beam deposition, for example.

5. Deposit Pb-Sn or other low temperature melting solder in a continuous band or ring 186 on top of the second SiO_2 layer or band 184.

6. Deposit on the bottom of a cover glass 188 a metal ring 190 to be coincident with the solder seal ring 186.
15

7. Install cover glass 188 over the assembly, as shown in Fig. 14B, with metal ring 190 abutting against the solder ring 186.

8. Place the assembly in an inert gas atmosphere, such as dry nitrogen, and apply heat to melt solder ring 186 to
20 obtain an air tight seal, with the inert gas trapped in interior region 192.

Referring to Fig. 15, there is shown a display 194 which is an RGB organic LED display. The dots 195 are ellipsis.
25 A complete display as 194 comprises a plurality of pixels such as 196. The pixels are arranged as a XY matrix to cover the entire surface area of a glass sheet coated with ITO. Each pixel includes a stacked LED structure as that shown in Fig. 2.

Instead of having fixed bias means as batteries 30, 31 and 32 (Fig. 2) each of the lines of terminals designated in Fig. 2 as blue (B), green (G) and red (R) are brought out and coupled to suitable horizontal and vertical scan processors 197 and 198, respectively, all under control of a display generator 199 which may be a TV unit. Accordingly, each matrix of LED's has at least two axes (x,y), and each LED is at the intersection of at least two of the axes. Also, the x-axis may represent a horizontal axis, and the y-axis a vertical axis. It is well known now to convert television signals such as the NTSC signals into the color components R, G and B for color displays. Monitors for computers which utilize red, green and blue for primary colors are also well known. The drive and control of such devices by vertical and horizontal scanning techniques are also known. The entire array of pixel structures deposited over the surface of the display is scanned employing typical XY scanning techniques as using XY addressing. These techniques are used in active matrix displays.

One can use pulse width modulation to selectively energize the red, green and blue inputs of each of the DH LED pixels according to desired signal content. In this manner, each of the LED's in each line of the display are selectively accessed and addressed and are biased by many means such as by pulse width modulation signals or by staircase generated voltages to enable these devices to emit single colors or multiple colors, so that light emitted from said structures creates an image having a predetermined shape and color. Also, one can serially scan each of the xy axes, and serially energize selected ones of the LED's

in the matrix to emit light for producing an image with colors created serially vertically. Selected ones of the LED's may be simultaneously energized.

As indicated above, the vertical layering technique shown in Fig. 2 allows the fabrication of the three color DH LED pixel within extremely small areas. This allows one to provide high definition displays such as displays that have 300 to 600 lines per inch resolution or greater. Such high resolution would not be obtainable using prior art techniques in which the organic emission layers or fluorescent mediums generating the different colors are laterally spaced from one another.

Based on modern standards one can provide a LED device as shown in Fig. 2 with an effective area small enough to enable hundreds of pixel diodes to be stacked vertically and horizontally within the area of a square inch. Therefore, the fabrication techniques enables one to achieve extremely high resolution with high light intensity.

In Fig. 16, another embodiment of the invention is shown for a multicolor LED device including the stacking of up to N individual LED's, where N is an integer number 1,2,3... N. Depending upon the state of the technology at any future time, N will have a practical limit. The stacked N levels of LED's can, for example, be provided using either the shadow masking process steps previously described for Figs. 12 (A-E), or the dry etching process illustrated in Figs. 13A through 13F. The base or bottom portion of the stacked array of Fig. 16 is a glass substrate 102 as shown in Fig. 13F, for example, with an ITO layer 101 formed over substrate 102. The immediately overlying

first LED device, and following LED devices in this example, each include in succession over ITO layer 101 an HTL layer 154, an EL layer 156, an ETL layer 158, a metal layer 160, and an ITO layer 162. The Nth level LED device 164 further includes a topmost
5 metal layer (see layer 152 of Fig. 13F) formed over the uppermost ITO layer 162 thereof. A passivation layer 119 is deposited over the stack, as in the color stack of Fig. 13F. The material for each EL layer 156 of each LED device is selected for providing a particular color for the associated LED. As in the three color
10 device, shorter wavelength (blue) devices must lie lower in the stack than the longer wavelength (red) devices to avoid optical absorption by the red emitting layers. The color selected for each respective LED and the actual number of stacked LED's are dependent upon the particular application, and the desired colors
15 and shading capability to be provided. Such multi-color devices can also be used in optical communications networks, where each different optical channel is transmitted using a different wavelength emitted from a given device in the stack. The inherently concentric nature of the emitted light allows for
20 coupling of several wavelengths into a single optical transmission fiber. In practical such stacked arrays, access holes are formed down to the ITO layer 162 of each device followed by the deposition of appropriate metallization for facilitating packaging and electrical connection to each of the
25 LED devices in the stack, in a manner similar to that described for the stacked multicolor LED device of Figs. 14A, 14B, and 14C, for example.

This device can be used to provide a low cost, high resolution, high brightness full color, flat panel display of any size. This widens the scope of this invention to displays as small as a few millimeters to the size of a building. The images
5 created on the display could be text or illustrations in full color, in any resolution depending on the size of the individual LED's.

Those with skill in the art may recognize various modifications to the embodiments of the invention described and
10 illustrated herein. Such modifications are meant to be covered by the spirit and scope of the appended claims. For example, a multicolor stacked LED device, such as the above-described three color device of Fig. 2, in another embodiment of the invention can be provided by forming LED 20 from a polymer device as shown
15 in Fig. 1C, or from a deposited metal phosphonate film, rather than having all three layers laid down in vacuo. The two remaining stacked LED's would be formed by vapor deposition.

What is Claimed is:

1. A multicolor light emitting device (LED) structure, comprising:

5 a plurality of at least a first and a second light emitting organic device (LED) stacked one upon the other, to form a layered structure, with each LED separated one from the other by a transparent conductive layer to enable each device to receive a separate bias potential to operate to emit light
10 through the stack.

2. The multicolor light emitting device structure of claim 1, wherein each of said LED's emits a different wavelength of light and therefore a different color when biased.

15

3. The multicolor light emitting device structure of claim 1, including at least first through third light emitting devices stacked upon one another, respectively.

20

4. The multicolor light emitting diode structure of claim 3, wherein said first device emits the color blue (B), said second device emits the color green (G) and third device emits the color red (R).

25

5. The multicolor light emitting device structure of claim 4, wherein said devices are stacked in the following sequence along the vertical axis starting from a bottom point and directed upward, wherein the first device emits a blue color, and

has the second device for emitting a green color located on top of the upper surface of said blue emitting device, with the third device for emitting a red color located on top of the upper surface of said green emitting device, whereby said blue emitting device of the shortest wavelength is at the bottom with the red emitting device of the longest wavelength on top when the structure is aligned vertically.

6. The multicolor light emitting device structure of claim 1, wherein each LED device is a transparent double heterostructure (DH) device fabricated from organic materials.

7. The multicolor light emitting device structure of claim 1, wherein each LED device is a transparent single heterostructure device fabricated from organic materials.

8. The multicolor light emitting device structure of claim 6, wherein said transparent conductive layer includes indium tin oxide (ITO).

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9. The multicolor light emitting device structure of claim 7, wherein said transparent conductive layer includes indium tin oxide (ITO).

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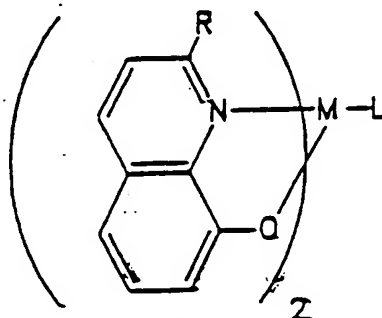
10. The multicolor light emitting device structure of claim 3, wherein said at least first, second, and third organic LED's are stacked in successive order over a common substrate.

11. The multicolor light emitting device structure of claim 10, wherein said substrate is at the bottom of said LED structure, and a topmost layer of said third organic LED included consists of indium tin oxide (ITO) material serving as a contact
5 for an underlying metal material layer.

12. The multicolor light emitting device structure of claim 6, wherein said transparent conductive layer comprises a metallic layer having a work function less than about four
10 electron volts, and an ITO layer on said metallic layer.

13. The multicolor light emitting device structure of claim 6, wherein said organic material is selected from the group consisting of trivalent metal quinolate complexes, trivalent
15 metal bridged quinolate complexes, Schiff base divalent metal complexes, tin (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare
20 earth mixed chelates.

14. The multicolor light emitting device structure of claim 13 wherein the trivalent metal quinolate complexes have the following formula.

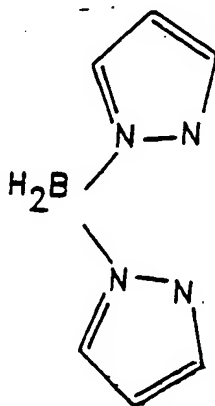


wherein R is selected from the group consisting of hydrogen, substituted and unsubstituted alkyl, aryl and a heterocyclic group, L represents a ligand selected from the group consisting of picolylmethylketone; substituted and unsubstituted salicylaldehyde; a group of the formula $R(O)CO-$ wherein R is as defined above; halogen; a group of the formula $RO-$ wherein R is as defined above; and quinolates and derivatives thereof.

15. The multicolor light emitting device structure of claim 13 wherein the metal bidentate ligand complexes have the following formula:



wherein M is selected from trivalent metals of Groups 3 - 13 of the Periodic Table and the Lanthanides, D is a bidentate ligand and L^4 is selected from the group consisting of acetylacetonate; compounds of the formula OR^3R wherein R^3 is Si or C and R is selected from the group consisting of hydrogen, substituted and unsubstituted alkyl, aryl, a heterocyclic group; 3, 5-di(t-bu) phenol; 2, 6-di(t-bu) phenol; 2, 6-di(t-bu) cresol and a compound of the formula



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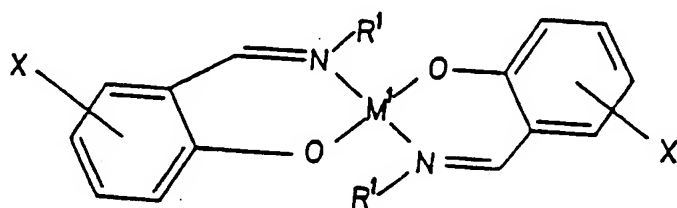
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16. The multicolor light emitting device structure of claim 15 wherein D is selected from the group consisting of 2-picolylylketones, 2-quinaldylketones and 2-(o-phenoxy)pyridineketones.

5

17. The multicolor light emitting device structure of claim 13 wherein the Schiff base divalent metal complexes are selected from those having the formula

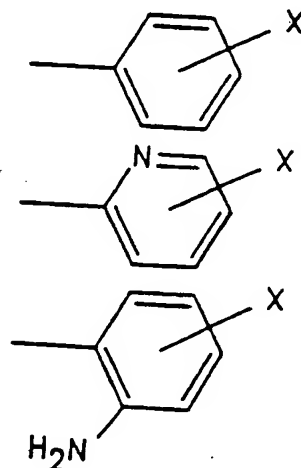
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wherein M' is a divalent metal chosen from Groups 2 - 12 of the Periodic Table, R' is selected from the group consisting of

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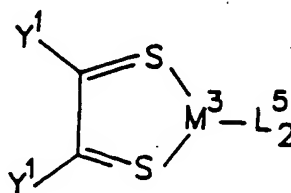
25 wherein X is selected from the group consisting of hydrogen, alkyl, alkoxy each having 1 to 8 carbon atoms, aryl, a heterocyclic group, phosphino, halogen and amine.

18. The multicolor light emitting device structure of claim 13 wherein the aromatic and heterocyclic polymers are selected from the group consisting of poly (para-phenylene vinylene), poly (dialkoxyphenylene vinylene), poly (thiophene),
 5 poly (phenylene), poly (phenylacetylene) and poly (N-vinylcarbazole).

19. The multicolor light emitting device structure of claim 13 wherein the rare earth mixed chelates comprise a
 10 Lanthanide bonded to a bidentate aromatic or heterocyclic group.

20. The multicolor light emitting device structure of claim 19 wherein the bidentate aromatic or heterocyclic group is selected from the group consisting of salicylaldehydes and
 15 derivatives thereof, salicyclic acid, quinolates, Schiff base ligands, acetylacetonates, phenanthroline, bipyridine, quinoline and pyridine.

21. The multicolor light emitting device structure of claim 19 wherein the divalent metal maleonitriledithiolate
 20 complexes have the formula

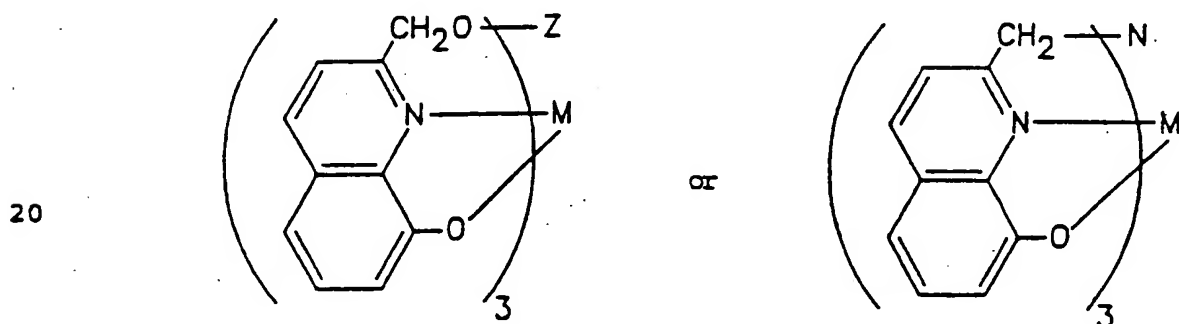


25 wherein M^3 is a metal having a +2 charge, Y^1 is selected from the group consisting of cyano and substituted and unsubstituted phenyl, and L^2 is a group having no charge.

22. The multicolor light emitting device structure of claim 21 wherein L^j is a group of the formula $P(OR)_3$ or $P(R)_3$, wherein R is selected from the group consisting of hydrogen, substituted and unsubstituted alkyl, aryl and a heterocyclic group.

23. The multicolor light emitting device structure of claim 13 wherein the bisphosphonates have the formula $M^2_2(O_3P-organic-PO_3)_2$, wherein M^2 is a metal ion and organic represents an aromatic or heterocyclic fluorescent compound bifunctionalized with phosphonate groups.

24. The multicolor light emitting device structure of claim 13 wherein the trivalent metal bridged quinolate complexes have the formula



wherein M is a trivalent metal ion and Z is selected from SiR or $P=O$ wherein R is selected from the group consisting of hydrogen, substituted or unsubstituted alkyl, aryl, or a heterocyclic group.

25. The multicolor light emitting device structure of claim 13 wherein the tin (iv) metal complexes have the formula SnL^1L^2 , wherein L^1 is selected from the group consisting of salicylaldehydes, salicyclic acid, and quinolates and L^2 is
5 selected from the group consisting of substituted and unsubstituted alkyl, aryl and a heterocyclic group.

26. The multicolor light emitting device structure of claim 13 wherein the molecular charge transfer complexes comprise
10 an electron acceptor complexed with an electron donor.

27. The multicolor light emitting device structure of claim 1, wherein said devices are stacked in an order dependent upon and in accordance with their respective emission wavelength
15 and absorption characteristics.

28. The multicolor light emitting device of claim 2, wherein the longest wavelength LED is on top of the stack in the vertical direction followed by successively shorter wavelength
20 LED's, with the shortest wavelength LED on the bottom of the stack.

29. A multicolor light emitting device structure, comprising:

25 a transparent substrate layer having deposited on a surface a first transparent conductive coating;

a first light emitting device deposited on said first transparent conductive coating;

a second transparent conductive coating deposited on the surface of said first device not in contact with said first coating;

5 a second light emitting device deposited on the surface of said second coating;

a third transparent conductive coating deposited on the surface of said second device not in contact with said second coating;

10 a third light emitting device deposited on the surface of said third coating; and

a further conductive coating deposited on the surface of said third device not in contact with said third coating.

15 30. The multicolor light emitting device structure of claim 29, wherein said first, second, third and fourth conductive coatings are adapted to receive individual sources of biasing potential, respectively.

20 31. The multicolor light emitting device structure of claim 29, wherein said devices and conductive layers are deposited to form a staircase profile, with said transparent substrate being of a greater length than said first device, with said first device being of a greater length than said second
25 device, with said second device of a greater length than said third device, wherein each step is covered by said respective conductive coating adapted for applying operating potentials to said device structures, and wherein said first through third

transparent conductive coatings allow light emitted by any of said devices, respectively, to pass through said transparent substrate layer.

5 32. The multicolor light emitting device structure of claim 29, wherein said further conductive coating, includes a third metal that reflects upward directed light back to said substrate.

10 33. The multicolor light emitting device structure of claim 32, wherein said further conductive coating further includes a relatively thin indium tin oxide (ITO) layer between said thick metal and said surface of said third device not in contact with said third coating, said ITO layer serving as a
15 contact for an underlying metal material layer of said third light emitting diode device.

 34. The multicolor light emitting device structure of claim 29, wherein said transparent substrate is glass, said first
20 conductive coating is indium tin oxide (ITO), and each of said second, third and further conductive coatings are comprised of an ITO layer disposed on a low work function metal layer.

 35. The multicolor light emitting device structure of
25 claim 29, wherein each of said devices are double heterostructures (DH), with said first device operative when biased to emit blue light (B), said second device operative when

biased to emit green light (G), said third device operative when biased to emit red light (R).

36. The multicolor light emitting device structure of claim 35, wherein each DH structure is comprised of organic compounds.

37. The multicolor light emitting device structure of claim 29, wherein each of said devices are single heterostructures (SH), with said first device operative when biased to emit blue light (B), said second device operative when biased to emit green light (G), and said third device operative when biased to emit red light (R).

38. The multicolor light emitting device structure of claim 29, wherein each of said devices are polymer structures, with said first device operative when biased to emit blue light (B), said second device operative when biased to emit green light (G), and said third device operative when biased to emit red light (R).

39. A multicolor display, comprising:
a plurality of multicolor light emitting device pixel structures arranged in rows and columns to provide a display surface with each pixel structure consisting of at least one multicolor light emitting device structure wherein each device structure comprises first, second and third light emitting devices (LED's) stacked one upon the other to form a layered

structure, with each LED separated by a transparent conductive layer, and whereby said display can be biased via said conductive layers to cause said multicolor light emitting devices to emit light when biased.

5

40. The multicolor display of claim 39, wherein said first LED emits blue light (B), said second LED emits green light (G) and said third LED emits red light (R).

10

41. The multicolor display of claim 39, wherein each LED device is a double heterostructure (DH) device capable of emitting light as a function of an organic compound employed in said device.

15

42. The multicolor display of claim 39, wherein each of said LED devices is a single heterostructure (SH) device capable of emitting light as a function of an organic compound employed in said device.

20

43. The multicolor display of claim 39, wherein each of said LED devices is polymer structured device capable of emitting light as a function of an organic compound employed in said device.

25

44. The display of claim 39, wherein said plurality of multicolor device structures as arranged in rows and columns on a glass substrate coated with a thin transparent layer of ITO and with each of said first, second and third LED devices of each

pixel stacked on said substrate to form a separate pixel location.

45. A method of fabricating a multicolor light
5 emitting device (LED) structure comprising the steps of:

forming a first transparent conductive layer upon
a transparent substrate;

depositing a first hole transporting layer upon
said first transparent conductive layer;

10 depositing a first organic emission layer upon
said first hole transporting layer to provide a first emission
color;

depositing a first electron transporting layer
upon said first emission layer;

15 depositing a second transparent conductive layer
upon said first electron transporting layer, said second
transparent conductive layer adapted to receive a first bias
potential;

20 depositing a second hole transporting layer upon
said second transparent conductive layer;

depositing a second organic emission layer upon
said second hole transporting layer to provide a second emission
color;

25 depositing a second electron transporting layer
upon said second emission layer; and

depositing a third transparent conductive layer
upon said second electron transporting layer, said third

transparent conductive layer adapted to receive a second bias potential.

46. The method of claim 45, further including the step
5 of shadow masking a region of said first transparent conductive layer prior to depositing said first hole transporting layer to expose said region of said first transparent conductive layer thereby enabling said first bias potential to be applied between said second transparent conductive layer and said region of said
10 first transparent conductive layer.

47. The method of claim 45, further including the step
of etching away a region of said first hole transporting layer to expose a portion of said first transparent conductive layer
15 thereby enabling said first bias potential to be applied between said second transparent conductive layer and said exposed portion of said first transparent conductive layer.

48. A method of fabricating a hermetically packaged
20 multicolor light emitting device (LED), comprising the steps of:

forming a first transparent conductive layer upon
a transparent substrate;

masking said first conductive layer for depositing
an SiO₂ layer thereupon in a concentric pattern;

25 forming on a portion of said first SiO₂ layer at least one multicolor LED, each including at least a first and a second organic light emitting devices (LED's) stacked one upon the other to form a layered structure upon said first SiO₂ layer;

depositing via shadow masking a plurality of metal contacts or circuit paths each having one end terminating near an outer edge of said first SiO₂ layer, and each having another end terminating on an individual biasing electrode of said at least one multicolor LED;

depositing via shadow masking a second SiO₂ layer as a ring concentric with said first SiO₂ layer and over outer portions of said plurality of metal contacts but leaving exposed said one ends thereof;

depositing a ring of low temperature melting solder over and concentric with said second SiO₂ ring;

depositing on the bottom of a cover glass a metal ring positioned to be coincident with said ring of solder;

installing said cover glass over said substrate and at least one multicolor LED, with said ring of solder abutting against said metal ring on said cover glass;

placing said assembly in an inert gas atmosphere; and

heating said ring of solder to melt the solder for both forming an air tight seal, and entrapping said inert gas in an interior region between the bottom of said cover glass and underlying substrate.

49. The method of claim 48, wherein said multicolor LED forming step further includes forming a plurality of multicolor LED devices on said first SiO₂ layer.

50. The method of claim 48, wherein said inert gas includes dry nitrogen.

51. The method of claim 48, wherein said first transparent layer includes indium tin oxide (ITO).

52. The method of claim 51, further including the step
5 of depositing a metal contact proximate an edge of and upon said ITO layer for serving as a cathode electrode.

53. The method of claim 49, further including the step
10 of depositing a metal contact proximate an edge and upon said first transparent conductive layer for serving as a cathode electrode.

54. The method of claim 53, wherein said first transparent conductive layer includes indium tin oxide (ITO).
15

55. A multicolor, energizable, light emitting structure, comprising:

at least three layers of conductive material;

a transparent, energizable, light emitting device (LED)
20 disposed between adjacent ones of said layers of conductive material, respectively, so that said LEDs are stacked on each other with one of said layers of conductive material disposed between each two of said LEDs and the other layers of conductive material are disposed on the outside of said LEDs;

25 said layers of conductive material disposed between adjacent ones of said LEDs and one of said outside layers being substantially transparent; and

means on each of said layers of conductive material for being connected to a bias for selectively energizing each of said LEDs.

5 56. The structure of claim 55, wherein each of said LEDs emits a different color.

57. The structure of claim 56, wherein said LEDs are stacked in a vertical array.

10

58. The structure of claim 57, further including:

a third LED in said stack;

the middle one of said LEDs being operative to emit light of a predetermined wavelength;

15 one of the other LEDs being operative to emit light of a longer wavelength; and

the lowest LED being operative to emit light of a shorter wavelength.

20 59. The structure of claim 57, further including:

a transparent substrate;

said stack of LEDs and layers of conductive material being supported by said transparent substrate in an order that corresponds to the length of the light wave that said
25 LEDs emit; and

said LED emitting the shortest wavelength is closest to said transparent substrate so that the light emitted

from each of said LEDs when it is energized is transmitted through the other LEDs and through said transparent substrate.

60. The structure of claim 59, further including:

5 a layer of anti-reflecting material disposed between said LED emitting the shortest wavelength and said transparent substrate so that the light emitted from each of said LEDs when it is energized is not reflected from said transparent substrate.

10

61. The structure of claim 59, further including:

a layer of reflective material adjacent said LED emitting the longest wavelength for reflecting light emitted from said LED back through said substrate.

15

62. The structure of claim 55, wherein said layer of conductive material includes indium-tin-oxide (ITO) and a metal.

63. The structure of claim 62, wherein said metal has
20 a work function of less than four electron volts.

64. The structure of claim 55, further including:

a transparent substrate;

25 said stack of LEDs and layers of conductive material being supported by said transparent substrate in an order that corresponds to the length of the light wave that said LEDs emit; and

said LED emitting the shortest wavelength is closest to said transparent substrate so that the light emitted from each of said LEDs when it is energized is transmitted through the other LED and through said transparent substrate with
5 substantially reduced absorption.

65. The structure of claim 64, further including:
a layer of anti-reflecting material disposed between said LED emitting the shortest wavelength and said
10 transparent substrate so that the light emitted from each of said LEDs when it is energized is not reflected from said transparent substrate.

66. The structure of claim 64, wherein said layer of
15 conductive material includes indium-tin-oxide (ITO) and a metal.

67. The structure of claim 66, wherein said metal has a work function of less than four electron volts.

20 68. The structure of claim 64, further including:
a layer of reflective material adjacent said LED emitting the longest wavelength for reflecting light emitted from said LED back through said substrate.

25 69. The structure of claim 55, wherein each of said LEDs is a double heterostructure.

70. The structure of claim 55, wherein each of said LEDs is a single heterostructure.

5 71. An energizable, light emitting structure, comprising:

a transparent substrate;

a first layer of substantially transparent, electrically conductive material supported on said substrate;

10 a transparent, energizable, light emitting device (LED) supported on said first layer of substantially transparent, electrically conductive material, said LED including an emission layer;

a second layer of electrically conductive material supported by said LED; and

15 said LED being operative to produce light and transmit it through said transparent substrate when energized.

72. The structure of claim 71, wherein said first and second layers comprise indium-tin-oxide.

20

73. The structure of claim 72, wherein said second layer further comprises a layer of metal that has a work function that is less than four electron volts.

25 74. The structure of claim 73, wherein said metal is from the group consisting of magnesium, arsenic and magnesium/gold alloy.

75. The structure of claim 71, further including:

said second layer of electrically conductive material being substantially transparent;

5 a second transparent, energizable, light emitting device (LED) supported on said second layer of electrically conductive material, said second LED including an emission layer;

a third layer of electrically conductive material supported by said second LED; and

10 said second LED being operative to produce light and transmit it through said first LED and through said transparent substrate when energized.

76. The energizable light emitting structure of claim 71, wherein said emission layer includes at least one material
15 is selected from the group consisting of trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate
20 complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth mixed chelates.

77. A multicolor, energizable, light emitting display comprising:

25 a plurality of energizable, light emitting structures;

each of said structures comprising a plurality of transparent, light emitting devices (LED) that are stacked on each other;

each of said LEDs in each of said structures being
5 operative to emit a different color light when energized; and

means for selectively energizing at least one of said LEDs in each of said structures so that the color produced by each of said light emitting structures is determined by which LED or LEDs in each light emitting structure is energized so that
10 light emitted from said structures creates an image having a predetermined shape and color.

78. The display of claim 77, wherein said energizable, light emitting structures are arranged in an array, said array
15 including at least two axes, and each of said light emitting structures is at the intersection of at least two of said axes.

79. The display of claim 78, wherein said axes define a horizontal axis and a vertical axis.

20

80. The display of claim 78, wherein said means for selectively energizing at least one of said LEDs in each of said structures includes:

means for selecting the structures and the LEDs
25 in those structures to be energized; and

means for serially scanning each of said axes so that said means for selectively energizing at least one of said LEDs scans along said axes so that said selected ones of said

LEDs at the intersection of said axes are serially energized to emit light so that said image and said colors are created serially.

5 81. The display of claim 77, wherein said means for selectively energizing at least one of said LEDs in each of said structures includes:

 means for substantially serially energizing said LEDs that are in said structures so that said image and said
10 colors are created serially by said structures.

 82. The display of claim 77, wherein said for means for selectively energizing said LEDs is operative to simultaneously energize selected ones of said LEDs in selected
15 ones of said structures so that said image and said colors are created simultaneously by said selected ones of said LEDs in said selected ones of said structures.

 83. The display of claim 77, wherein each of said
20 structures further includes:

 a transparent substrate;

 said LEDs each having a bottom and a top and defining a stack of LEDs having a bottom and a top, said stack being supported on said transparent substrate;

25 a first layer of substantially transparent, electrically conductive material, said first layer being disposed between said bottom LED and said transparent substrate;

at least one second layer of substantially transparent, electrically conductive material, said second layers being disposed between adjacent ones of said LEDs;

5 a first layer of electrically conductive material, said first layer being disposed adjacent the top of said top LED; and

means on each of said layers of electrically conductive material for being connected to a bias for selectively energizing each of said LEDs.

10

84. The display of claim 83, wherein each of said layers of substantially transparent, electrically conductive material and said layer of electrically conductive material includes a layer of indium-tin-oxide.

15

85. The display of claim 83, wherein each of said layers of substantially transparent, electrically conductive material, and said layer of electrically conductive material, includes a layer of metal and a layer of indium-tin-oxide.

20

86. The display of claim 85, wherein said metal has a work function of less than about four electron volts.

87. The display of claim 83, further including:

25

a layer of reflective material disposed on the layer of electrically conductive material adjacent the top of said top LED so that light from said LEDs is reflected through said transparent substrate by said layer of reflective material.

88. The display of claim 87, further including:

said stack of LEDs is supported by said transparent substrate in an order that corresponds to the wavelength of the light that said LEDs emit; and

5 said LED emitting the shortest wavelength is closest to said transparent substrate so that the light emitted from each of said LEDs when it is energized is transmitted through the other LEDs and through said transparent substrate.

10 89. The display of claim 88, further including a layer of anti-reflecting material disposed between said LED emitting the shortest wavelength and said transparent substrate so that the light emitted from each of said LEDs when it is energized is not reflected from said transparent substrate.

15 90. The display of claim 77, further including:
a transparent substrate;
each of said LEDs having a top and a bottom;
at least two layers of substantially transparent,
20 electrically conductive material, one of said layers being disposed on said transparent substrate;

the bottom of one of said LEDs in each of said structures being supported on said one layer of substantially transparent, electrically conductive material;

25 the others of said layers of substantially transparent, electrically conductive material being disposed between the remainder of said LEDs so that said LEDs define a stack;

a layer of electrically conductive material supported on the top of said LED in said stack that is furthest from said transparent substrate; and

means on each of said layers of substantially transparent, electrically conductive material and on said layer electrically conductive material for being connected to a bias for selectively energizing each of said LEDs.

91. The display of claim 90, wherein each of said layers of substantially transparent, electrically conductive material, and said layer of electrically conductive material include a layer of indium-tin-oxide.

92. The display of claim 90, wherein said layers of substantially transparent, electrically conductive material and each of said layers of electrically conductive material include a layer of metal and a layer of indium-tin-oxide.

93. The display of claim 92, wherein said metal has a work function of less than about four electron volts.

94. The display of claim 90, further including:
a layer of reflective material disposed on said layer of substantially transparent, electrically conductive material adjacent the top of said top LED so that light is reflected through said transparent substrate by said layer of reflective material.

95. The structure of claim 94, wherein

said stack of LEDs is supported by said transparent substrate in an order that corresponds to the wavelength of the light that said LEDs emit, and

5 said LED emitting the shortest wavelength is closest to said transparent substrate so that the light emitted from each of said LEDs when it is energized is transmitted through the other LEDs and through said transparent substrate.

10 96. The structure of claim 95, further including:

a layer of anti-reflecting material disposed between said LED emitting the shortest wavelength and said transparent substrate so that the light emitted from each of said LEDs when it is energized is not reflected from said transparent
15 substrate.

97. The display of claim 77, wherein said plurality of LED's include:

three LEDs;

20 each of said LEDs being a double heterostructure (DH);

said LED closest to said transparent substrate being operative when energized to emit blue light;

said LED furthest from said transparent substrate
25 being operative when energized to emit red light; and

said other LED being operative when energized to emit green light.

98. The multicolor light emitting display of claim 97, wherein each of said LEDs includes an emission layer containing an organic material selected from the group consisting of trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin
5 (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth
10 mixed chelates.

99. The display of claim 77, wherein said plurality of LED's include:

three LEDs;
15 each of said LEDs being single heterostructures (SH);
said LED closest to said transparent substrate being operative when energized to emit blue light;
said LED furthest from said transparent substrate
20 being operative when energized to emit red light; and
said other LED being operative when energized to emit green light.

100. The multicolor light emitting display of claim 99,
25 wherein each of said LEDs includes an emission layer containing an organic material selected from the group consisting of trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin

(iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth
5 mixed chelates.

101. A method of fabricating a multicolor, energizable light emitting structure, comprising the steps of:

providing a transparent substrate;
10 providing a first substantially transparent electrically conductive layer on said transparent substrate;
providing a first transparent, light emitting diode (LED) on said substrate, said first LED being operable when energized to emit a light of a first predetermined wavelength;
15 providing a second substantially transparent, electrically conductive layer on said first LED;
providing a second transparent, light emitting diode (LED) on said second substantially transparent, electrically conductive layer, said second LED being operable
20 when energized to emit a light of a second predetermined wavelength, that is longer than said first predetermined wavelength; and
an electrically conductive layer on said second (LED).

25

102. A method as in claim 101, wherein
said steps of providing said first and second LEDs comprises the steps of forming each of said LEDs by;

depositing a hole transporting layer on said first and second substantially transparent, electrically conductive layers;

depositing an emission layer on each of said hole transporting layers; and

depositing an electron transporting layer on each of said emission layers.

103. The method of claim 102, wherein each of said emission layers includes a material selected from the group consisting of trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth mixed chelates.

104. A method as in claim 103, wherein each of said substantially transparent electrically conductive layers and said layer of electrically conductive layer are comprised of indium-tin-oxide.

105. A method as in claim 102, further including:
the step of providing a layer of substantially transparent metal between said LEDs; and

a layer of said substantially transparent electrically conductive material on each of said layers of substantially transparent metal.

5 106. A method as in claim 105, wherein said metal has a work function of less than about four electron volts.

107. A method as in claim 105, wherein said metal is from the group consisting of magnesium, arsenic and magnesium/gold alloy.

108. A method as in claim 101, wherein said layer of electrically conductive material has a reflective surface for reflecting light emitted from said LEDs through said transparent substrate.

109. A method as in claim 101, further including the step of:

providing an electrical contact on each of said layers of substantially transparent, electrically conductive material, and on said layer of electrically conductive material so that each of said layers can be connected to a source of bias potential.

110. A transparent energizable, light emitting device (LED), comprising:

an emission layer, a hole transporting layer and an electron transporting layer;

said emission layer being disposed between said hole transporting layer and said electron transporting layer;

a first layer of substantially transparent electrically conductive material, and a second layer of electrically conductive material, said first layer being on said hole transporting layer, said second layer being on said electron transporting layer; and

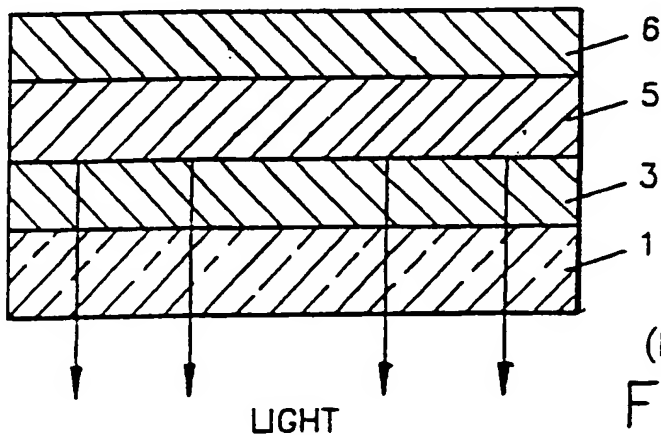
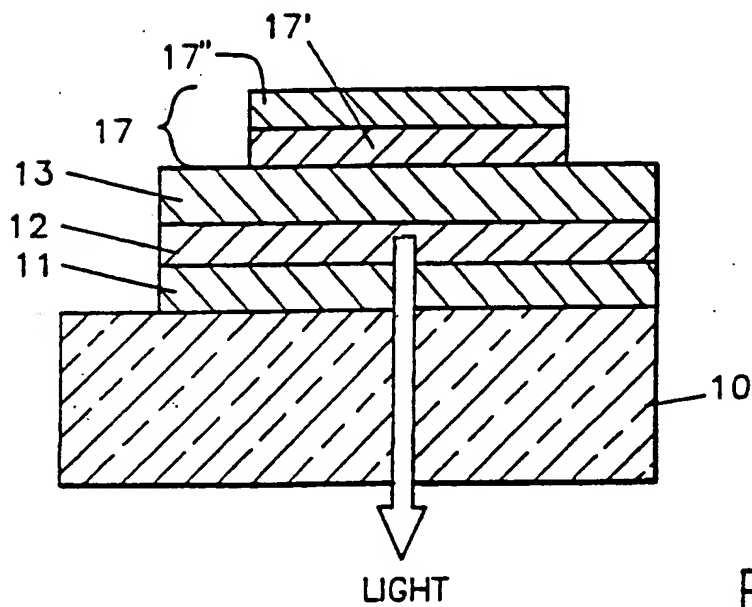
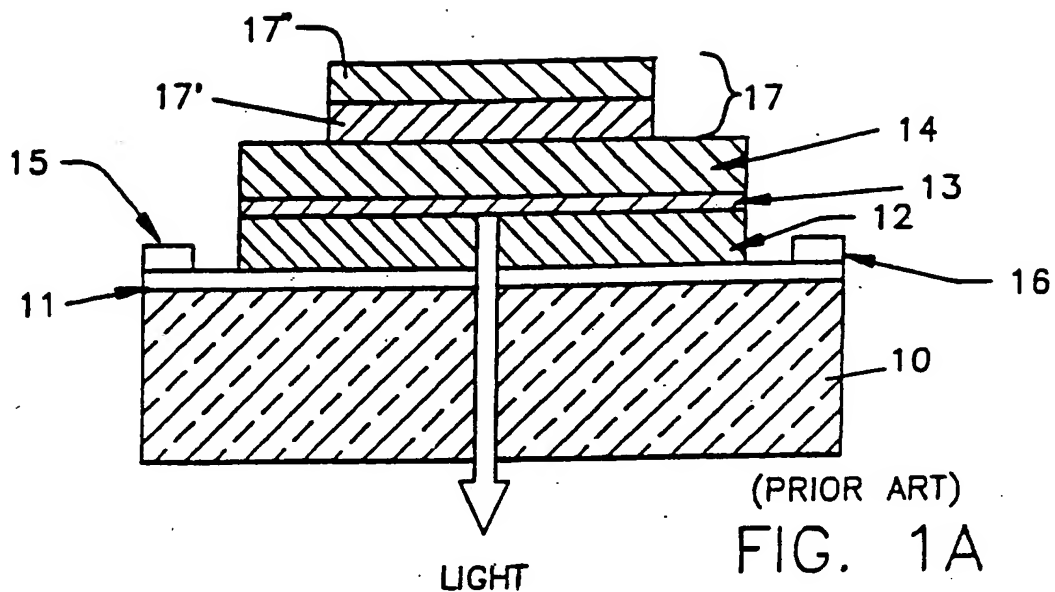
said emission layer consists of material selected from the group consisting of trivalent metal quinolate complexes, trivalent metal bridged quinolate complexes, Schiff base divalent metal complexes, tin (iv) metal complexes, metal acetylacetonate complexes, metal bidentate ligand complexes, bisphosphonates, divalent metal maleonitriledithiolate complexes, molecular charge transfer complexes, aromatic and heterocyclic polymers and rare earth mixed chelates.

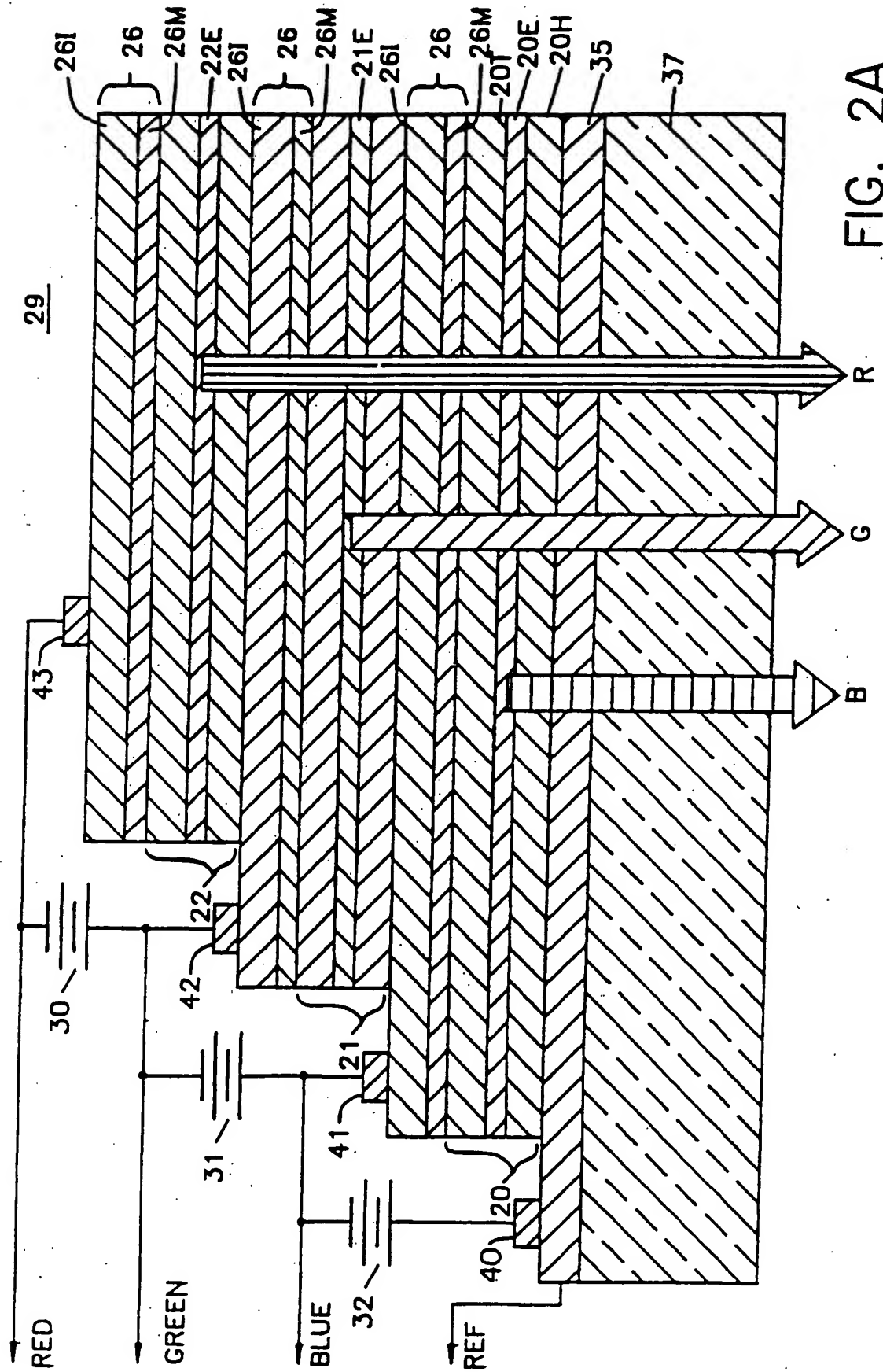
111. The device of claim 110, wherein

said emission layer is no more than about 200Å thick;

said hole transporting layer is no more than about 1000Å thick; and

said electron transporting layer is no more than about 1000Å thick.





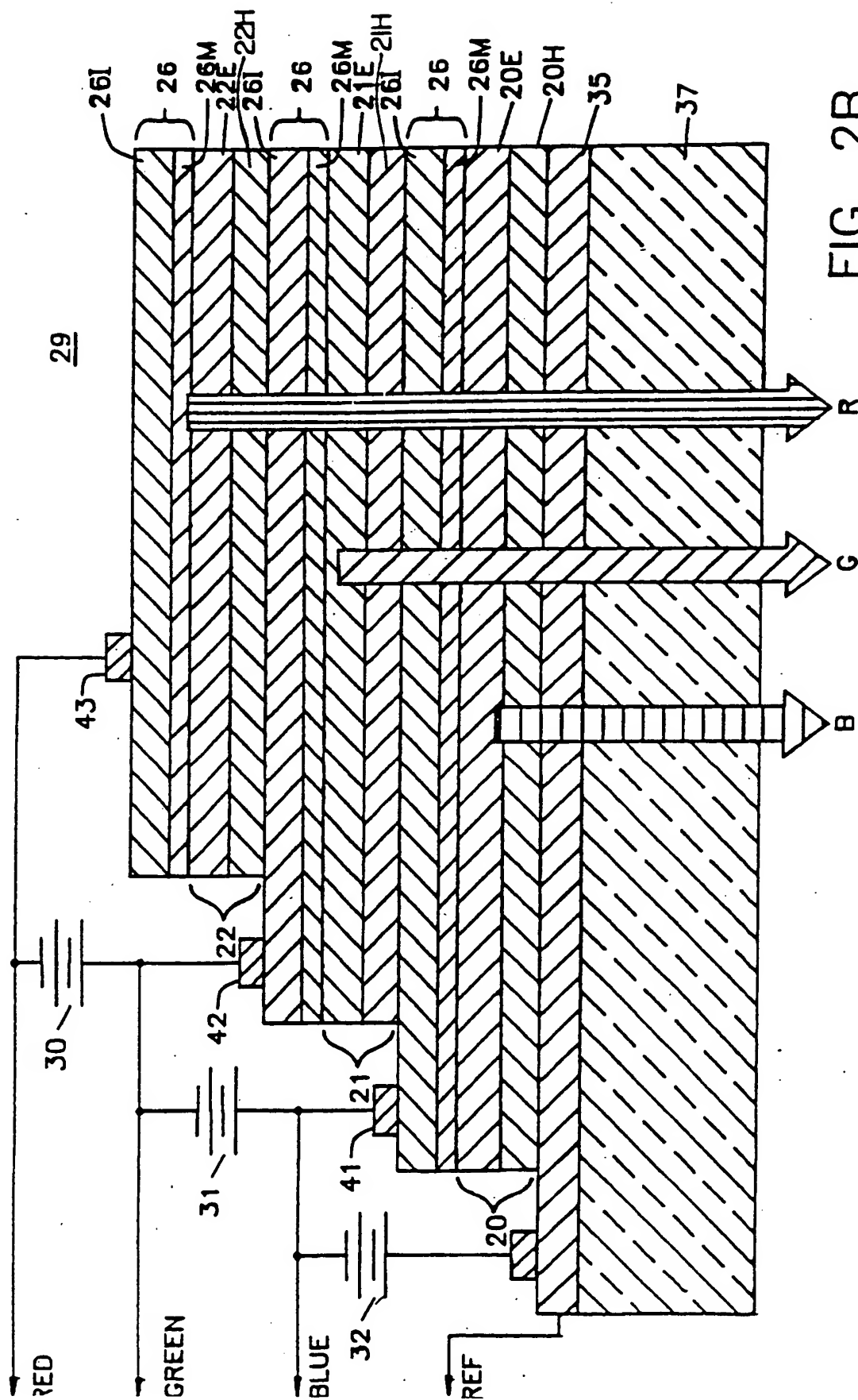


FIG. 2B

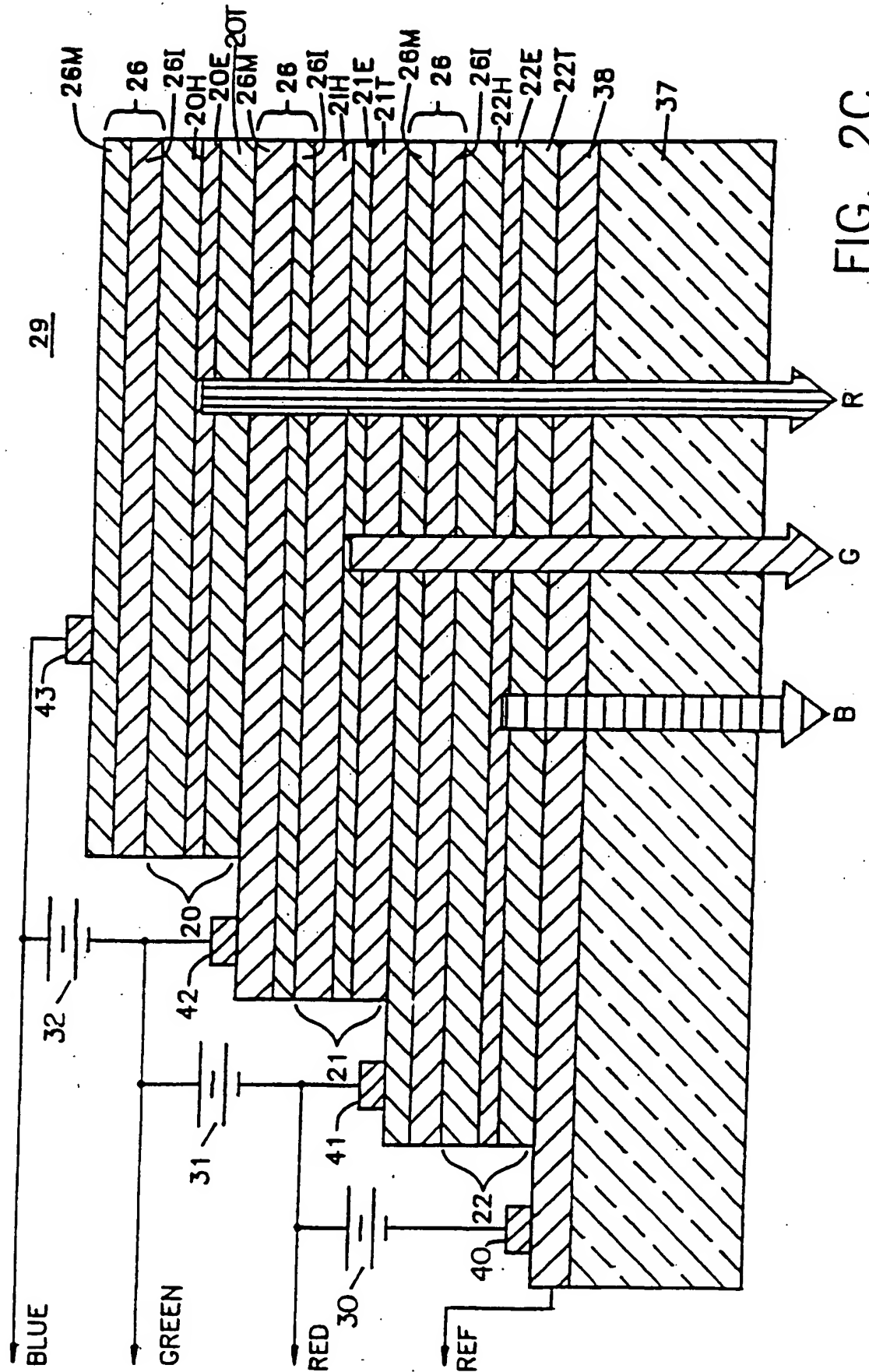


FIG. 2C

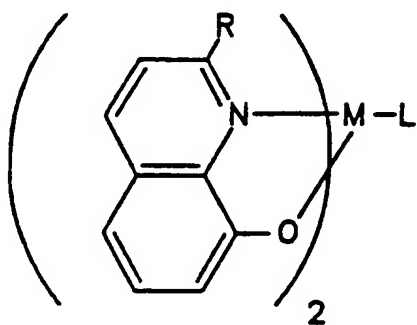


FIG. 3

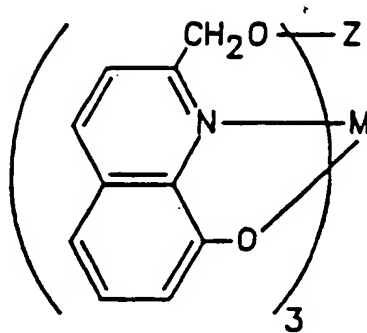


FIG. 4A

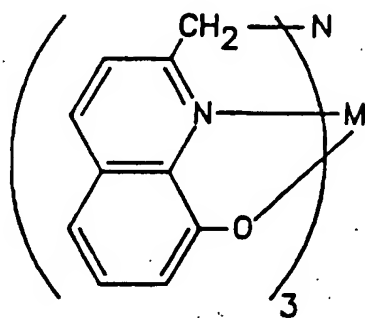
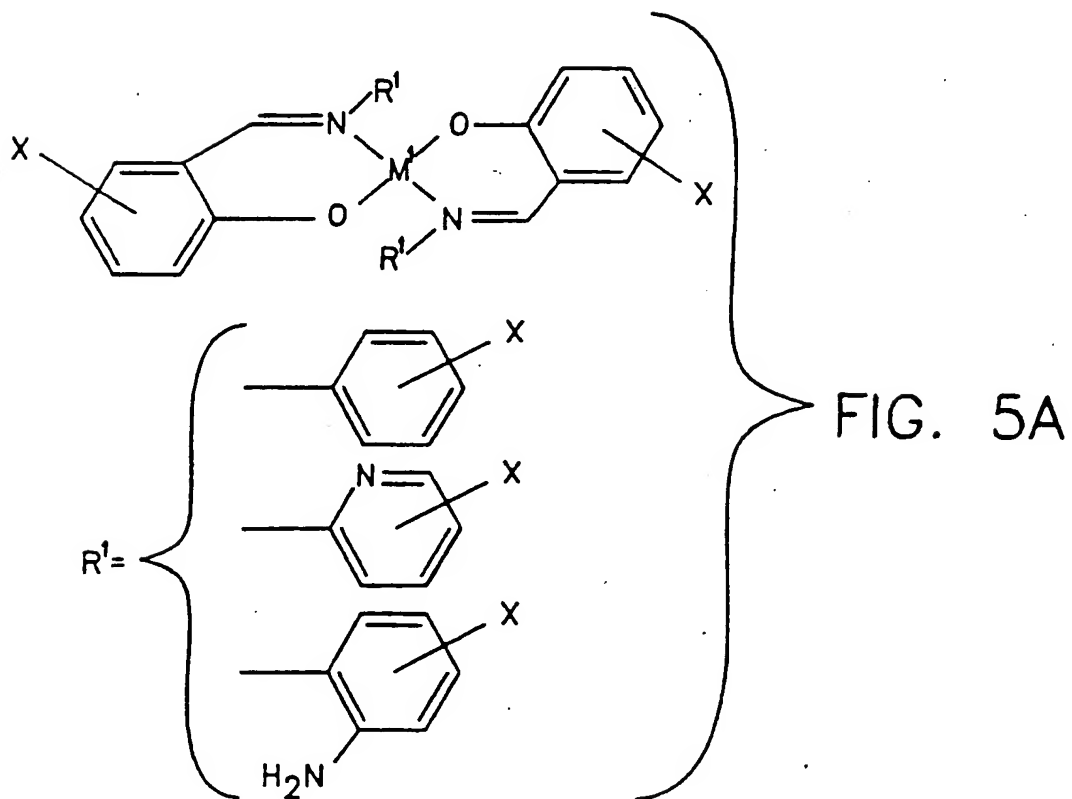


FIG. 4B



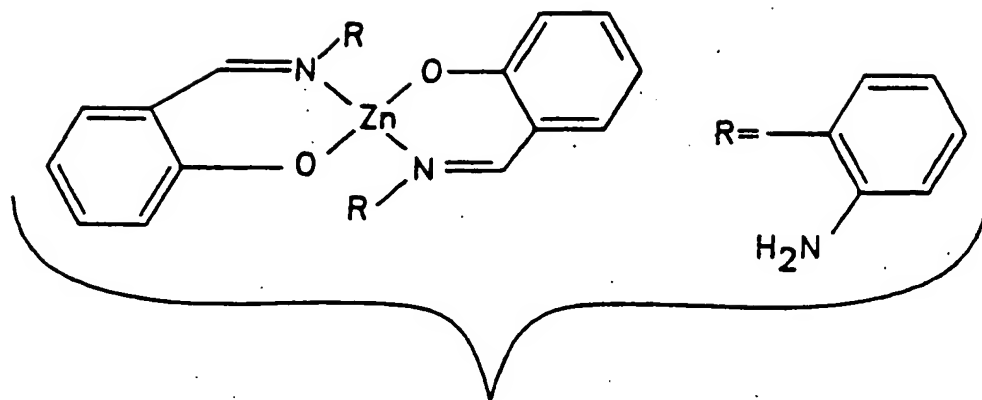


FIG. 5B

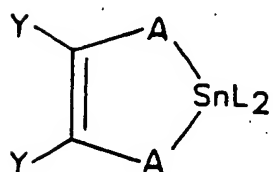


FIG. 6

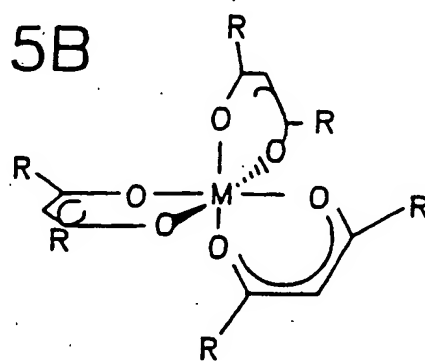
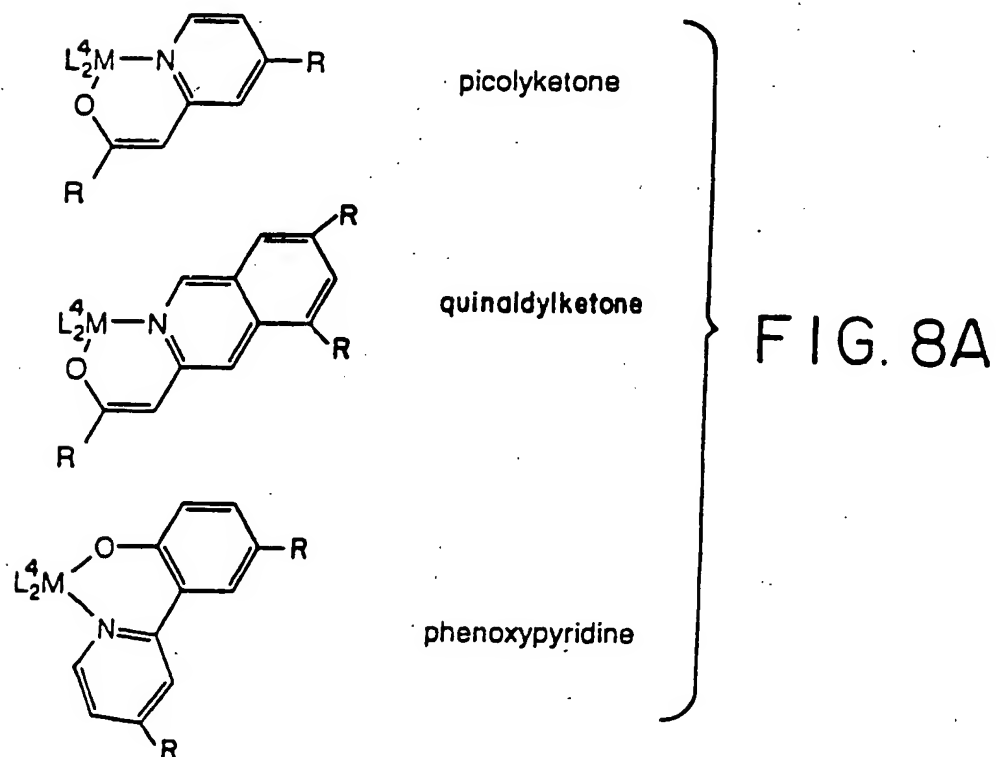


FIG. 7



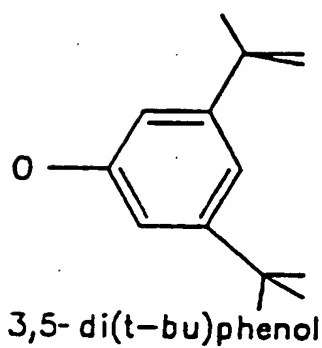


FIG. 8B

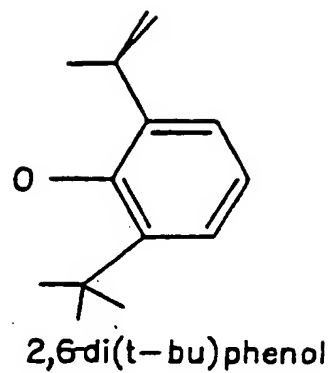


FIG. 8C

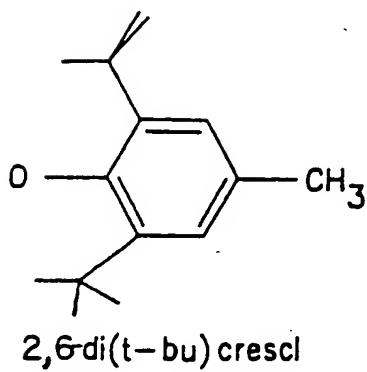


FIG. 8D

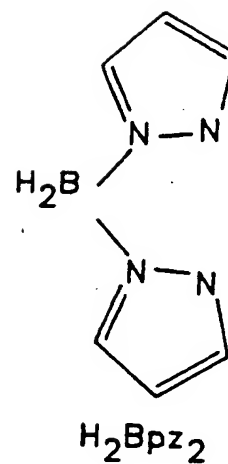


FIG. 8E

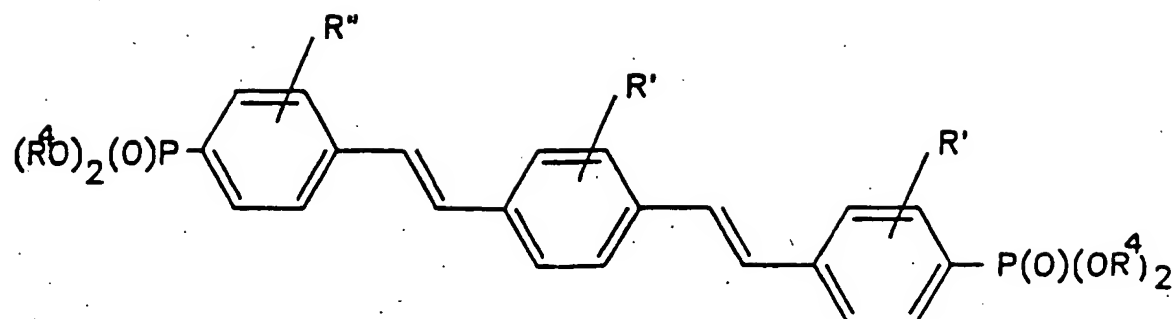


FIG. 9A

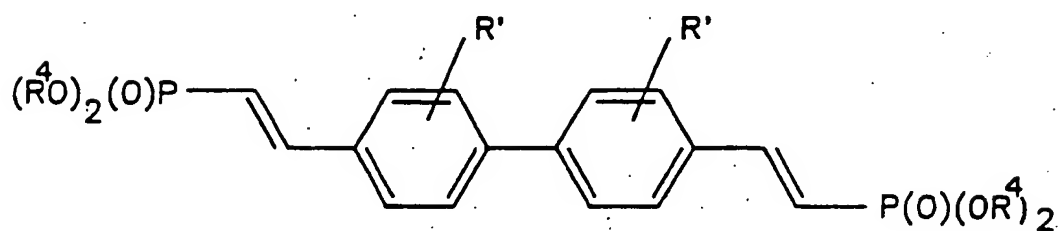


FIG. 9B

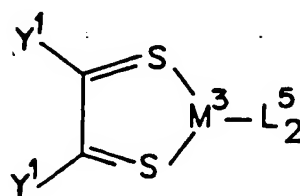


FIG. 10

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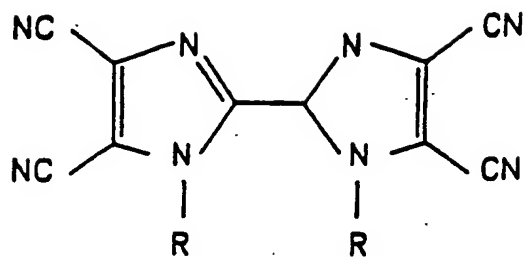


FIG. 11A

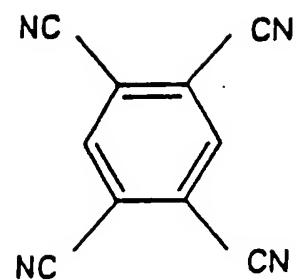


FIG. 11B

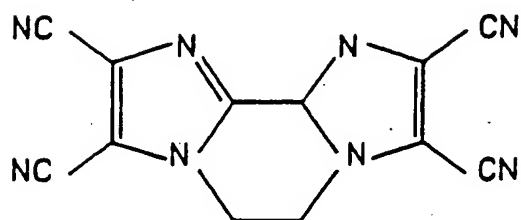


FIG. 11C

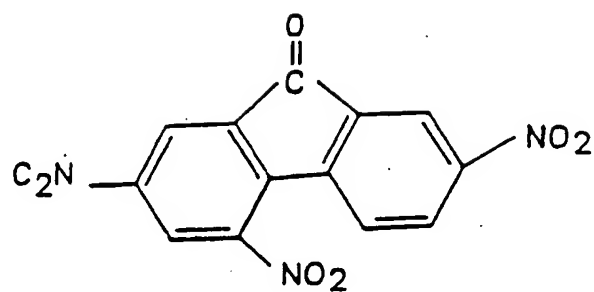


FIG. 11D

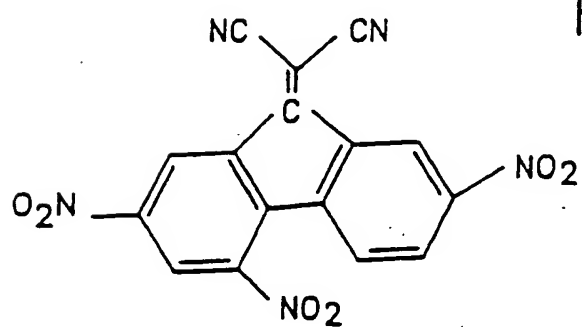


FIG. 11E

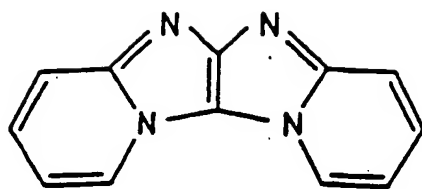


FIG. 11F

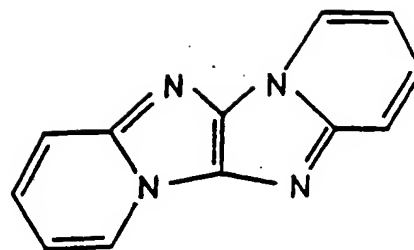


FIG. 11G

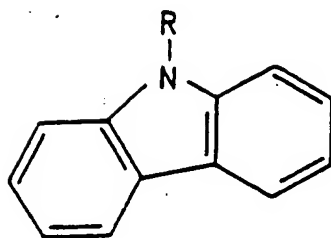


FIG. 11H

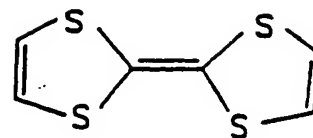


FIG. 11I

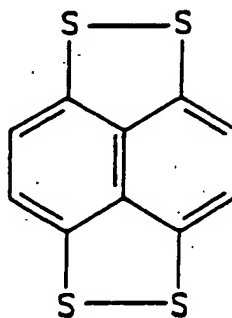


FIG. 11J

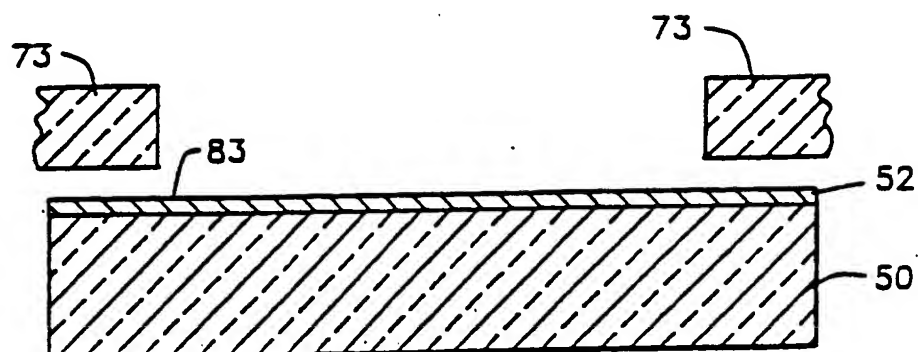


FIG. 12A

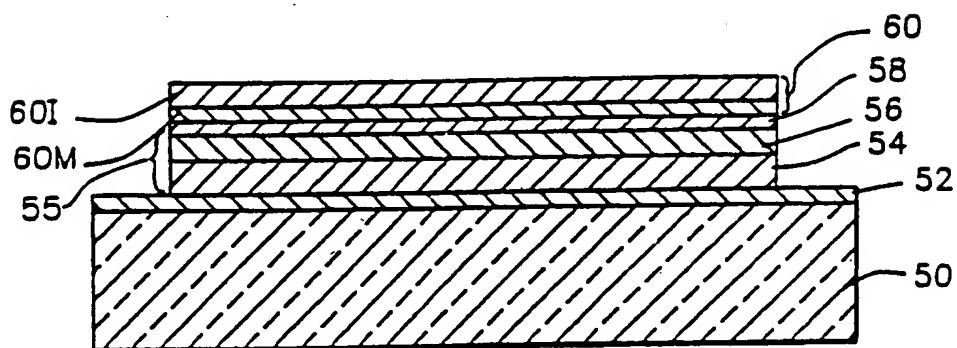


FIG. 12B

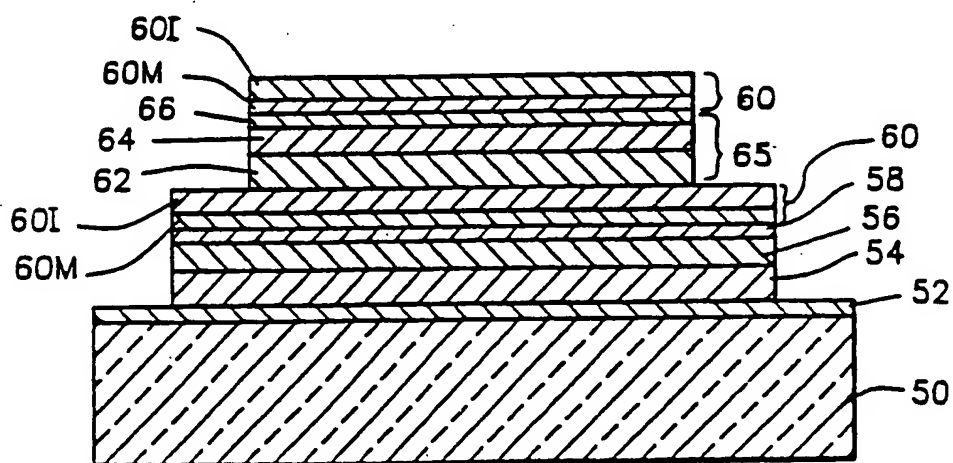


FIG. 12C

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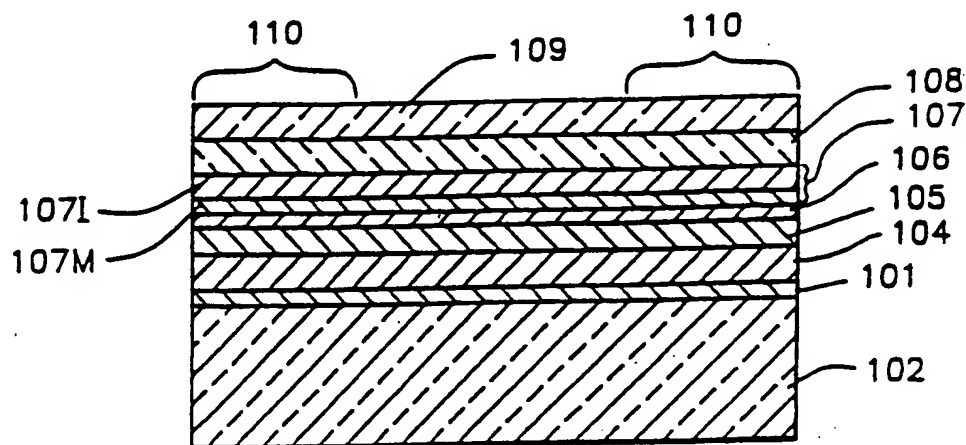


FIG. 13A

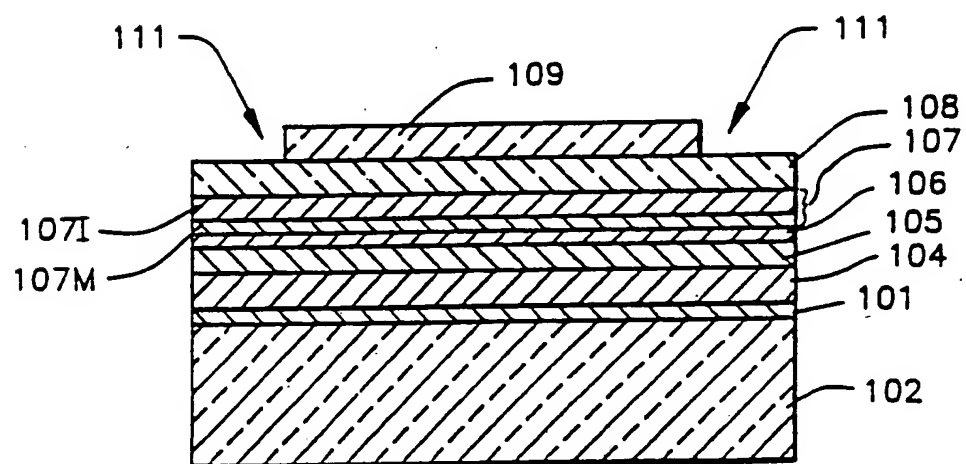


FIG. 13B

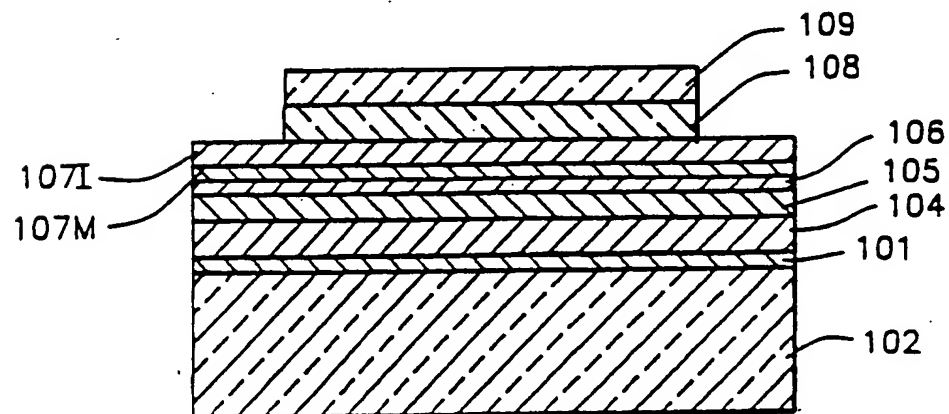


FIG. 13C

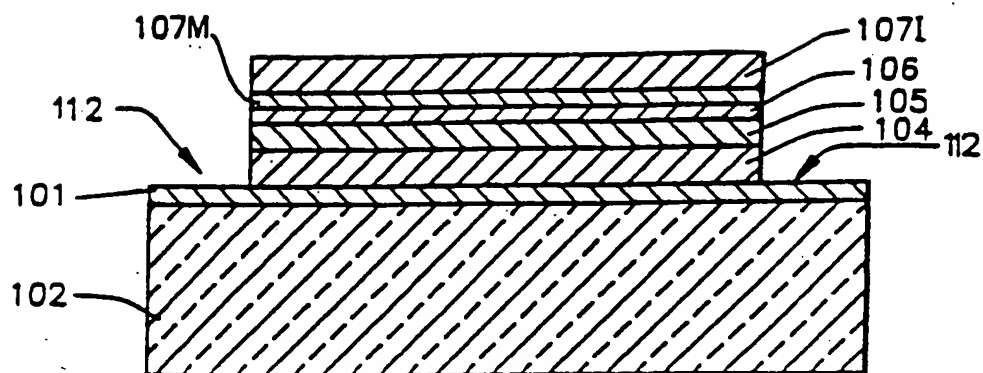


FIG. 13D

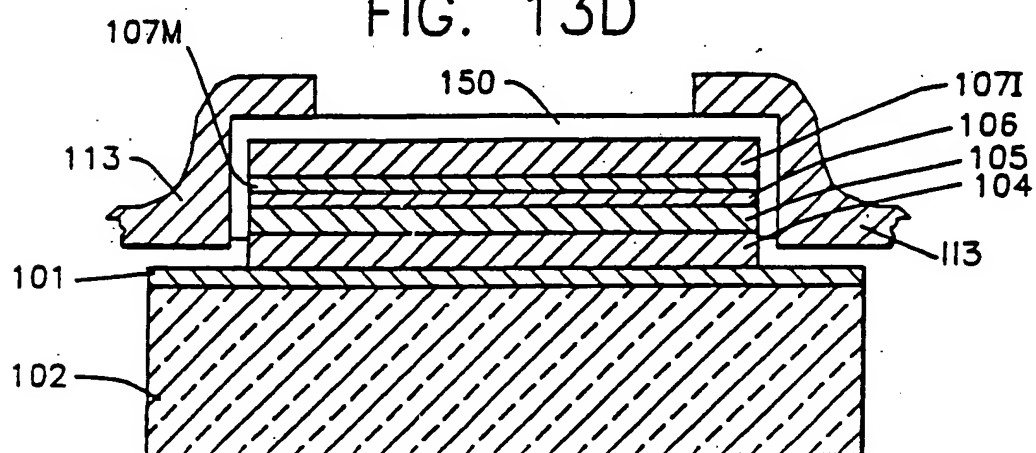


FIG. 13E

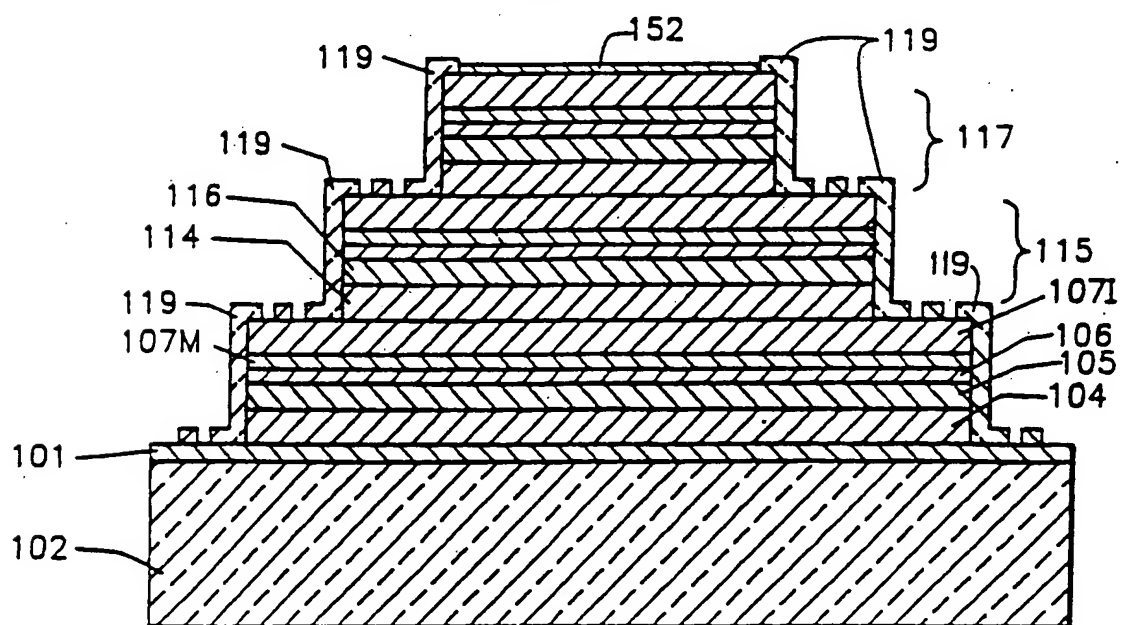


FIG. 13F

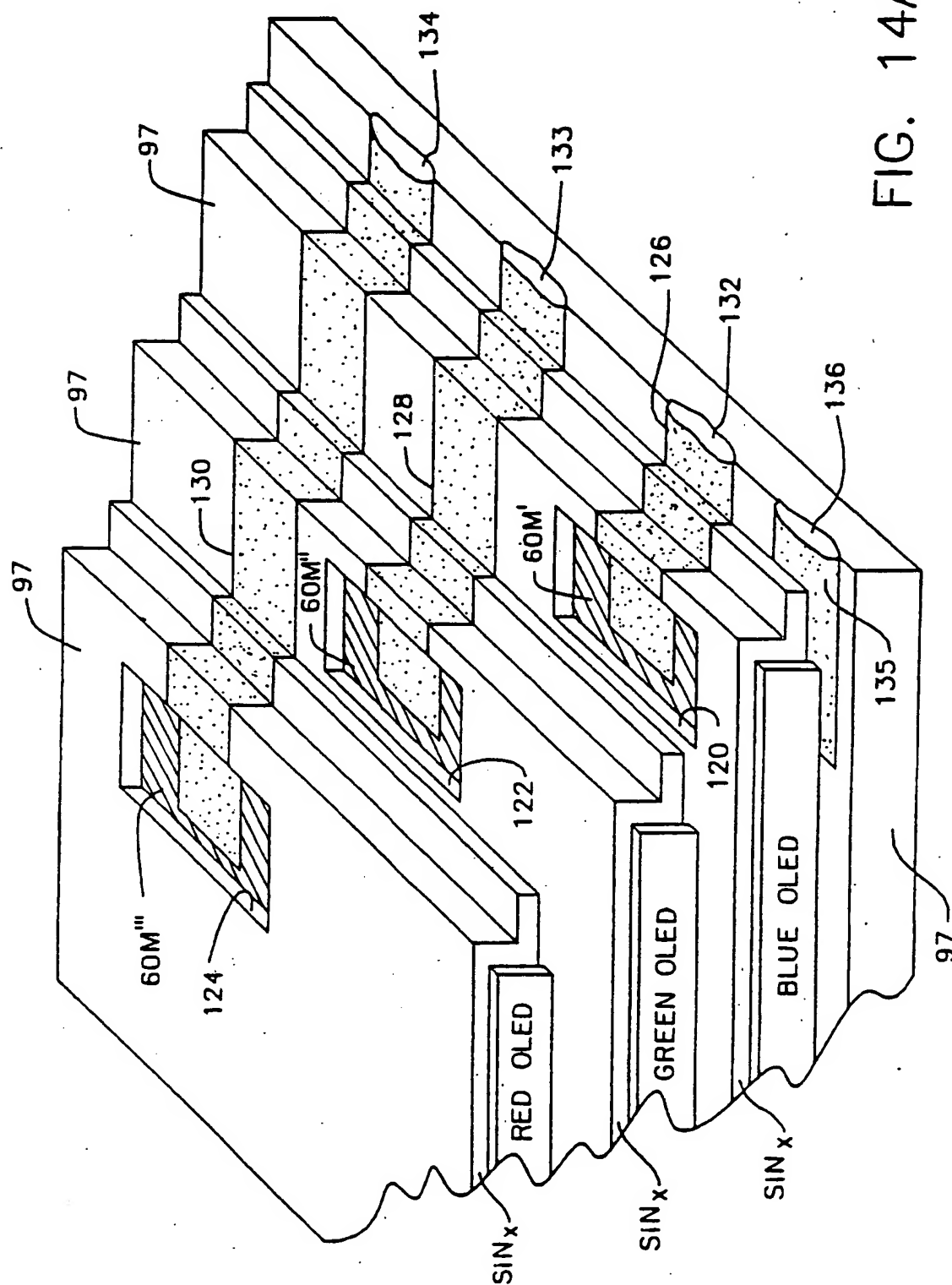


FIG. 14A

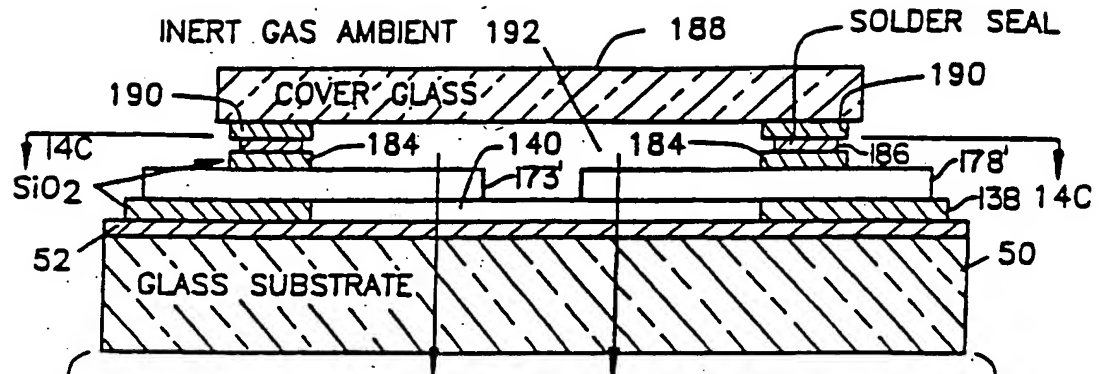


FIG. 14B

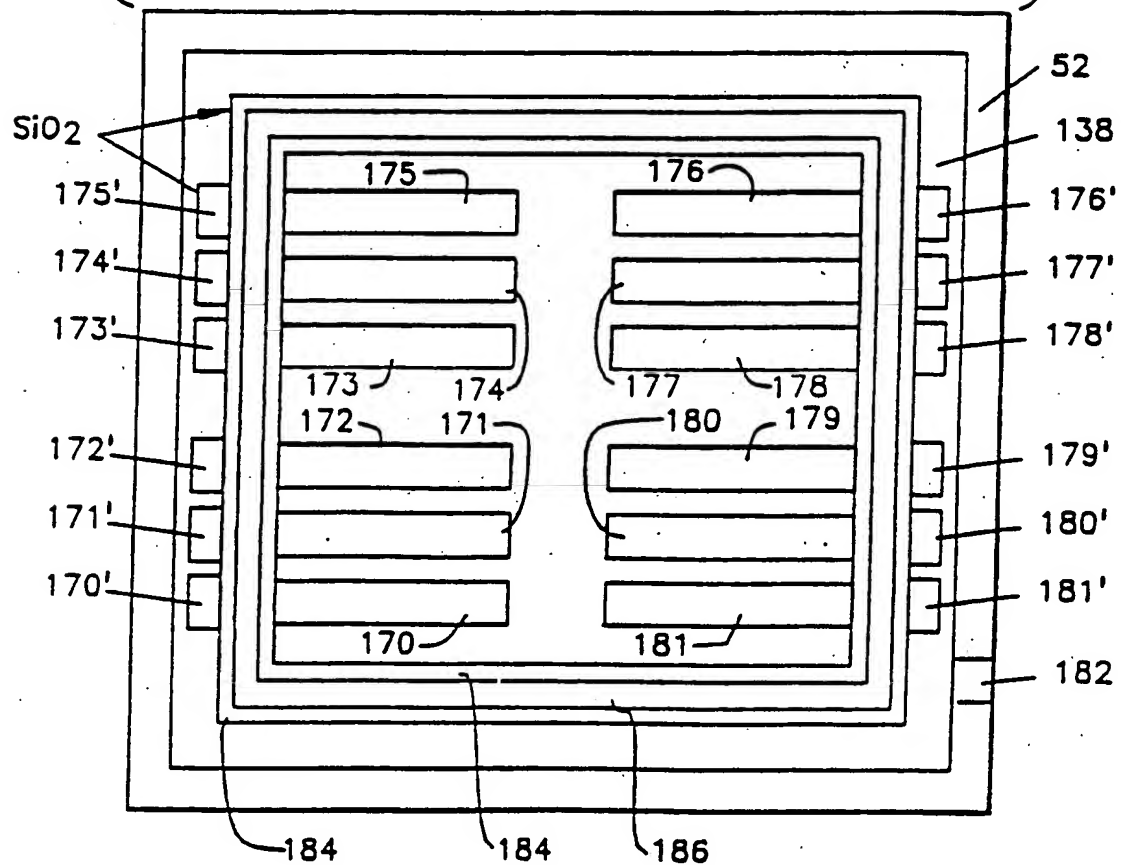
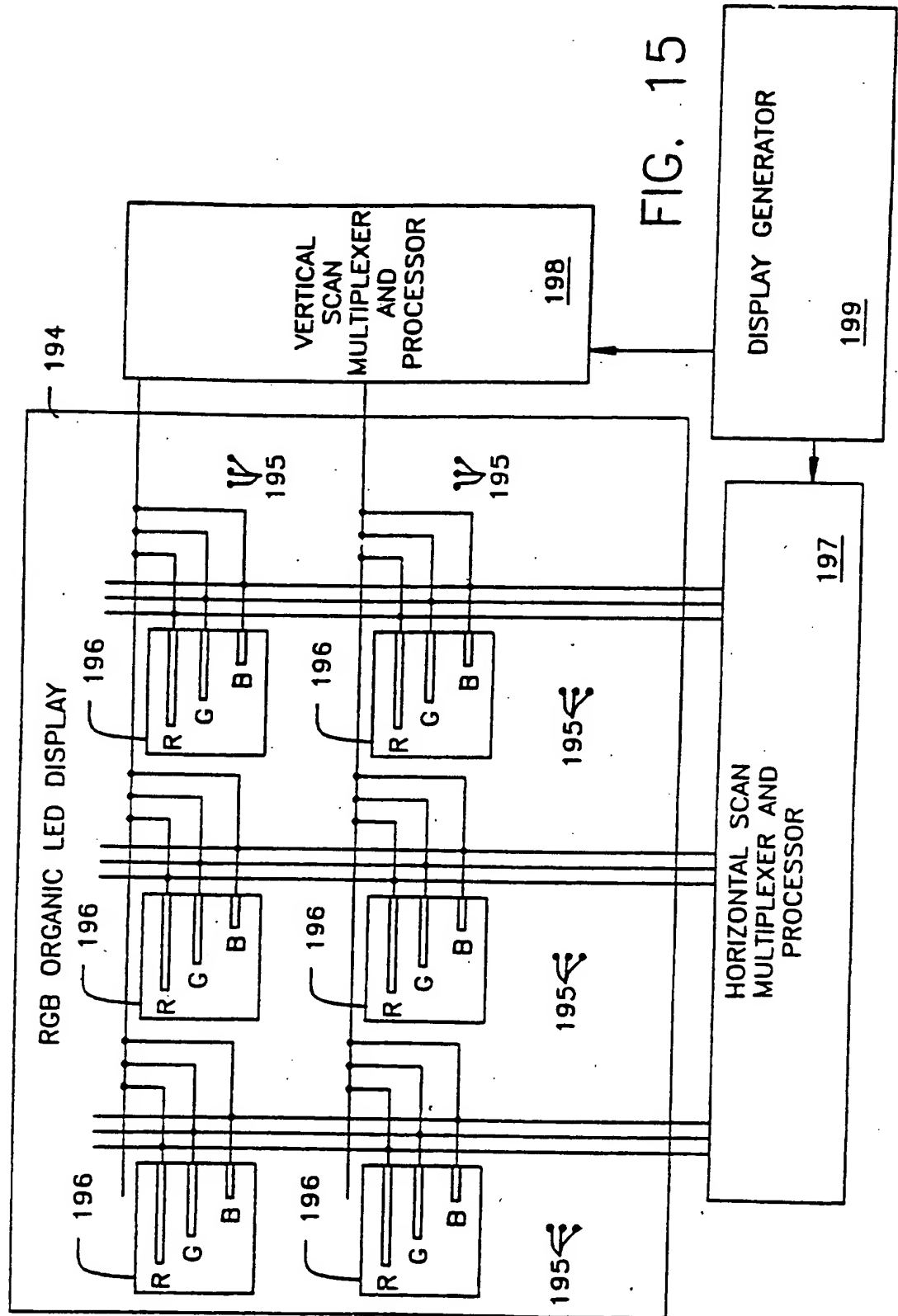


FIG. 14C



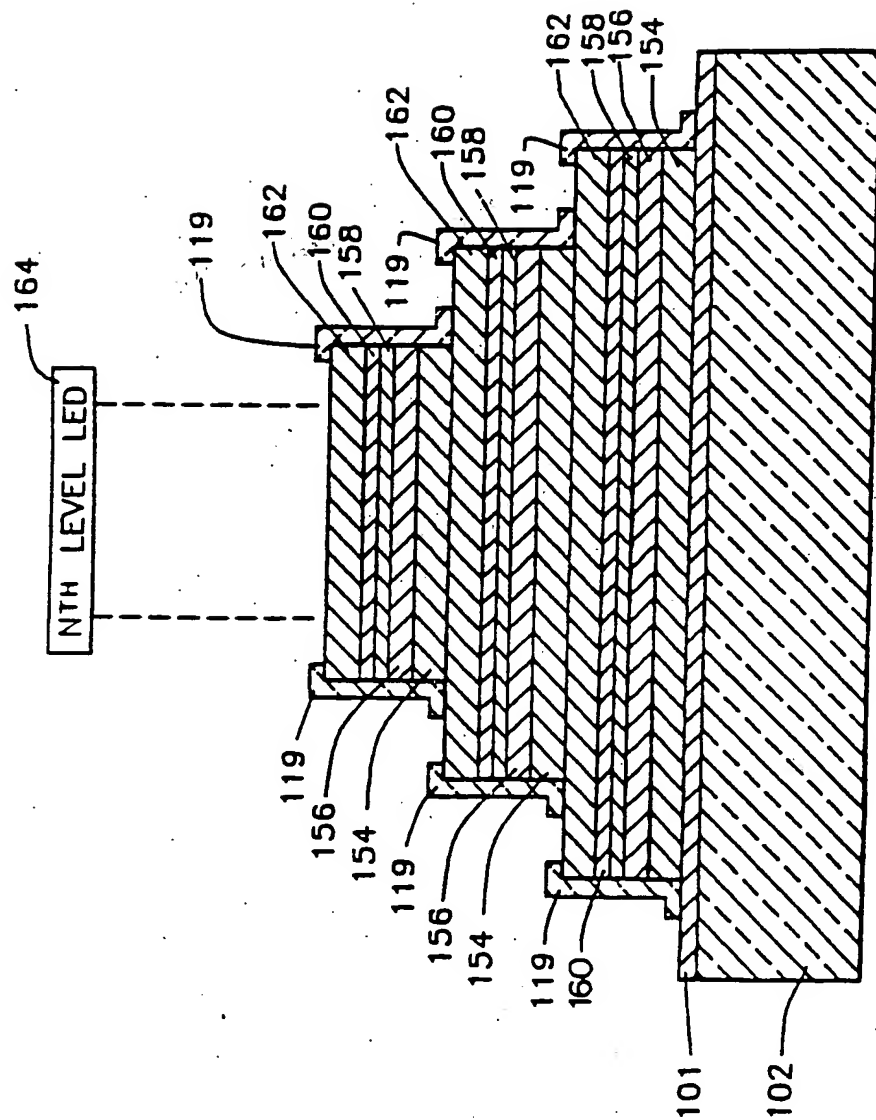


FIG. 16

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